GUIDE

What a turnkey vision inspection station includes, and what it does not

The scope of supply of a vision station, item by item, and the trades your plant or line builder usually provides.

BY ADDASCAN ENGINEERING TEAM · TECHNICAL REVIEW: Frank Guo (https://www.linkedin.com/in/frank-g-15b59b57) · PUBLISHED 3 OCTOBER 2026 · 7 MIN READ

Discuss the scope for your line

// SHORT ANSWER

A turnkey vision inspection station from addaScan includes the vision hardware and software licence, inspection recipes, mounting and a shroud, the I/O and PLC signals, a reject with confirmation where the scope includes one, an operator screen, FAT and SAT, training and the handover documents. Usually excluded or supplied by you: conveyor changes, utilities to the point of use, PLC program changes by your line's own integrator, civil and structural work, electrical supply, the plant network, travel outside Gauteng and annual support.

// ON THIS PAGE

1. What a turnkey station includes

2. What is excluded or supplied by you
3. Who does which trade
4. How this matches the scope levels on the cost guide
5. Items decided case by case
6. Scope checklist before you accept a quotation
7. Questions about station scope

Key points

- Turnkey means the station is delivered working on your line: hardware, licence, recipes, mounting, signals, testing, training and documents.
- Changes to the line around the station, utilities, electrical supply, civil work and the plant network usually stay with your plant or your line builder.
- PLC program changes are made by whoever owns the program; we supply the interface description and test the signals with them.
- The reject and its confirmation sensor are part of a complete station; on smaller scopes the station drives your existing reject unless the proposal adds one.
- Every proposal lists what is included and what is excluded, so nothing is assumed on either side.

What a turnkey station includes

A turnkey station is one that addaScan hands over working on your line, not a box of parts. Everything the station needs to inspect, decide and signal the result is in scope, together with the testing that proves it and what your team needs to run it. The list below is the usual scope; the proposal for your line confirms each item, as the delivery stages describe.

ITEM	WHAT IT COVERS	NOTES

ITEM	WHAT IT COVERS	NOTES
Vision hardware	Cameras or smart cameras, lenses, lighting, and a PC or vision controller where the station needs one.	Chosen on the sample test; the models are listed in the proposal.
Software licence	The inspection software licence for the station, including deep-learning modules where a check needs them.	On a smart camera the software runs in the camera.
Inspection recipes	One recipe per product on the agreed list, with limits set on your samples and recorded.	Products added after handover follow the support plan.
Mounting	Brackets and stands for cameras and lights, with adjustment that can be locked and marked.	So the position can be restored after cleaning or a knock.
Shroud or lighting enclosure	A shroud that keeps daylight and overhead light out and protects the optics.	A washdown or dust-rated housing where the area needs one.
I/O and PLC signals	Trigger, result, ready and fault signals, and recipe selection, by hard-wired I/O or a network link.	Written into the PLC interface description.

ITEM	WHAT IT COVERS	NOTES
Reject with confirmation	The reject device and a sensor that confirms each failed product left the line.	Part of a complete station; on smaller scopes, see below.
Operator screen	Result, recent reject images, counts, the recipe in use and faults; limit changes restricted by user role.	A display at the station or a page on your HMI, as the proposal states.
FAT and SAT	A factory acceptance test on the agreed samples before delivery, and a site acceptance test on your line.	Pass criteria agreed before the station is built.
Training	Operator training for daily use; technician training for cleaning, reference checks and new products.	For the shifts and people named in the proposal.
Documents	Station description, wiring and I/O list, PLC interface description, operating instructions, recipe files, configuration backup and support plan.	Handed over with the signed SAT.

What is excluded or supplied by you

Some work sits outside the station because it changes your line, your building or your systems, or because the law or your site rules say who may do it. These items are listed as excluded or supplied by you in every proposal, unless the proposal includes them by name.

ITEM	WHAT IT MEANS	USUALLY SUPPLIED BY
Conveyor changes	Lengthening a conveyor, moving guides, adding a transfer or changing product spacing.	Your fitters or the line builder. A complete station brings its own conveyor section.
Utilities to the point of use	Compressed air for an air-jet or pusher reject, and any other utility the station needs.	Your plant. The proposal states what the station needs and where.
PLC program changes by the line's own integrator	Changes to a PLC program that another integrator or your own programmer owns.	The owner of the program, working from our interface description.
Civil and structural work	Floor fixings, plinths, platforms, moving other equipment, cable trays outside the station.	Your contractor.

ITEM	WHAT IT MEANS	USUALLY SUPPLIED BY
Electrical supply	A new circuit, isolator or distribution board work to feed the station.	Your registered electrician or electrical contractor.
Plant network	Switch ports, IP addresses, firewall rules, remote-access approval and any server for images or data.	Your IT team.
Travel outside Gauteng	Travel and accommodation for survey, installation and SAT outside Gauteng.	Quoted separately.
Annual support	Support after handover beyond what the support plan includes.	Quoted separately; the support plan states what is covered.

Why the electrical supply stays with your plant. Under South Africa's Electrical Installation Regulations, only a registered person may issue a certificate of compliance for an electrical installation (Electrical Installation Regulations, 2009, regulation 9). A new circuit or isolator for the station is therefore done by your registered electrician or electrical contractor, who certifies it as part of your installation. addaScan wires the station itself from the agreed supply point.

Why the plant network stays with your IT team. A station that sends results to a PLC network, stores images on a server or allows remote help touches your network and its security rules. Your IT team assigns ports and addresses and decides on remote

access; the station is set up to match. The image archive guide covers what to store and for how long. The guide to vision data for OEE and MES lists what a station can hand over.

Who does which trade

Most misunderstandings on a vision project are about the work around the station, not the station. Reading across a trade shows where addaScan's scope ends and yours begins.

TRADE	ADDASCAN (THE STATION)	YOUR PLANT OR LINE BUILDER
Vision engineering	Optics, lighting, recipes, limits, test records.	Your quality team supplies samples and approves limits and borderline decisions.
Mechanical	Camera and light mounts, shrouds, housings; in a complete station, the conveyor section, handling and guarding.	Changes to the existing line: guides, conveyors, transfers, removing obstructions.
Electrical	Wiring inside the station and to its I/O, from an agreed supply point.	Supply to that point, isolation and the certificate of compliance for the installation.

TRADE	ADDASCAN (THE STATION)	YOUR PLANT OR LINE BUILDER
Pneumatics	Reject valve and tubing inside the station, where the reject is in scope.	Compressed air to the point of use.
PLC	The vision side of every signal, the interface description, and testing the signals together.	Changes to the PLC program, by whoever owns it.
IT and network	Station network settings as agreed with your IT team.	Switch ports, addresses, firewall, remote access, servers.
Civil and structural	None.	Floors, plinths, platforms and structural changes.
Machine safety	Guarding that is part of a complete station.	Safety of the line as a whole. The vision station is not a safety function.

How this matches the scope levels on the cost guide

The cost and budget guide groups stations into three scope levels. The items above apply to all three; what changes is how much of the line around the camera is part of the station.

SCOPE LEVEL	STATION INCLUDES	STAYS WITH YOU
Single-view check	One smart camera or camera with lighting, mounting and shroud, recipes, digital I/O to your existing PLC and reject, FAT, SAT, training, documents.	The reject and conveyor already on the line, PLC program changes if another party owns the program, utilities, electrical supply, network.
Multi-view station	Several cameras and lights, a PC or vision controller with its licence, a recipe per product, a PLC network link, an operator screen, FAT, SAT, training, documents.	As for a single-view check, plus the network port and addresses for the PLC link.
Complete station	A multi-view station plus a conveyor section, product handling, a reject with confirmation, and guarding.	Utilities and electrical supply to the station, civil work, the plant network, and changes to the line upstream and downstream.

The indicative ranges on the cost guide include vision hardware, software licence, application engineering, installation in Gauteng, FAT, SAT and training. They exclude VAT, changes to your line outside the station, utilities, travel outside Gauteng, annual support, and line-scan, 3D or telecentric systems, which are priced per project after the sample test.

Items decided case by case

A few items move between the two lists depending on the line. They are the ones to read most carefully in a quotation.

- **The reject.** Included in a complete station. On smaller scopes, the station uses the reject already on the line if it can remove the failed product reliably; if not, a new reject or a confirmation sensor is added and listed. How tracking and confirmation work is covered in the PLC and reject integration guide.
- **PLC program changes.** Made by whoever owns the program. If that is us, the work is listed; if it is your integrator or programmer, the proposal names the signals they need to add.
- **Conveyor and guides.** Excluded on smaller scopes, included as a conveyor section in a complete station. Where products are not presented consistently, the proposal states what has to change on the line.
- **Housings.** A standard shroud is included; a washdown or dust-rated housing is included where the area needs one and is listed as such.
- **Number of products.** Recipes are included for the products on the agreed list. Products added later follow the support plan.

Scope checklist before you accept a quotation

- Every view and check is named, with the products it covers.

- The reject is named: existing, new, or part of a complete station, with or without confirmation.
- The PLC signals are listed, and it is clear who changes the PLC program.
- Utilities, electrical supply and network needs are stated, with who provides each.
- FAT and SAT pass criteria are written down, including the sample set and the speed.
- Training names the groups to be trained; the document set is listed.
- Travel, support after handover and anything else excluded is listed as excluded.

The same questions help when comparing suppliers; the guide to choosing a machine vision integrator adds the rest.

// FAQ

Questions about station scope

What does turnkey mean for a vision inspection station?

That the station is handed over working on your line: hardware, licence, recipes, mounting, signals to your PLC and reject, FAT and SAT, training and documents, from one supplier. It does not mean every trade around the station. Line changes, utilities, electrical supply, civil work and the plant network are listed separately, as included or excluded.

Is the reject mechanism included?

In a complete station, yes, together with a confirmation sensor. On a single-view check or a multi-view station, the station usually drives the reject already on your line. Where there is none, or it cannot confirm removal, the proposal adds one or states what has to change.

Who changes the PLC program?

Whoever owns it. Where your line’s own integrator or programmer owns the program, they make the changes from our PLC interface description, and we test the signals together. Where we are given access and agreement to change it, that work is listed in the quotation.

Are compressed air and power included?

No. Utilities and the electrical supply to the point of use are provided by your plant. The proposal states what the station needs and where. Electrical installation work is done by your registered electrician or electrical contractor, who issues the certificate of compliance.

Are training and documentation included?

Yes. Operator and technician training, the station description, wiring and I/O list, PLC interface description, operating instructions, recipe files, a configuration backup and the support plan are part of the handover.

Is support after handover included in the price?

The support plan agreed at handover is included and states what is covered. Annual support beyond that is quoted separately, and the indicative ranges on the cost guide exclude it.

What if an item is not mentioned in the quotation?

Ask before you accept it. Each proposal lists what is included and what is excluded; anything that appears in neither list should be settled in writing before the station is built, not at installation.

SOURCES

1. Explanatory notes on the Electrical Installation Regulations, 2009 (General Notice 258 of 2012) (https://www.gov.za/sites/default/files/gcis_document/201409/35180gen258.pdf) (Department of Labour, Government Gazette 35180, read 2026-10-03; regulation 9(1): only a registered person may issue a certificate of compliance)

RELATED: How we deliver a project → Cost & budget guide → PLC & reject integration → Commissioning procedure → Choosing a machine vision integrator → Preparing samples → Support →

// NEXT STEP

Agree the scope before the station is built

Start an assessment

Describe the product, the defect and the line, and what is already there: reject, PLC, space. We reply within two working days with the questions that decide the scope.