continuously for several days in real plant environment. Below figure shows the memory performance (stability) when data transfer happen for weeks or months.

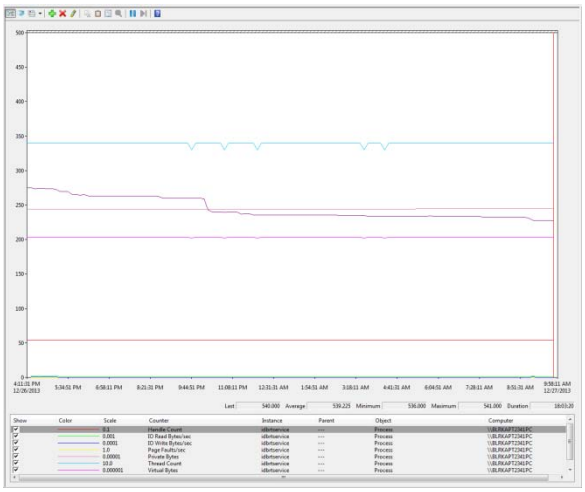

Fig. 5. Memory Usage and Performance

V. CONCLUSION

Data communication between PLC and external application is necessary. External application plays the role of a bridge between hardware and database. SCADA system depends on flow of data between engineering platform and other systems. This communication helps to create a secure and high speed connection and results in smooth data transfer.

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