

# MUHANDISLIK

## & IQTISODIYOT

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ijtimoiy-iqtisodiy, innovatsion texnik,  
fan va ta'limga oid ilmiy-amaliy jurnal

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ТАШКЕНТСКИЙ ФИЛИАЛ



# **muhandislik** **& iqtisodiyot**

ijtimoiy-iqtisodiy, innovatsion texnik,  
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- 05.01.02 – Tizimli tahlil, boshqaruv va axborotni qayta ishlash
- 05.01.03 – Informatikaning nazariy asoslari
- 05.01.04 – Hisoblash mashinalari, majmualari va kompyuter tarmoqlarining matematik va dasturiy ta'minoti
- 05.01.05 – Axborotlarni himoyalash usullari va tizimlari. Axborot xavfsizligi
- 05.01.06 – Hisoblash texnikasi va boshqaruv tizimlarining elementlari va qurilmalari
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- 05.05.06 – Qayta tiklanadigan energiya turlari asosidagi energiya qurilmalari
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- 05.09.01 – Qurilish konstruksiyalari, bino va inshootlar
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- 10.00.06 – Qiyosiy adabiyotshunoslik, chog'ishtirma tilshunoslik va tarjimashunoslik
- 10.00.04 – Yevropa, Amerika va Avstraliya xalqlari tili va adabiyoti
- 08.00.01 – Iqtisodiyot nazariyasi
- 08.00.02 – Makroiqtisodiyot
- 08.00.03 – Sanoat iqtisodiyoti
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- 08.00.07 – Moliya, pul muomalasi va kredit
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- 08.00.11 – Marketing
- 08.00.12 – Mintaqaviy iqtisodiyot
- 08.00.13 – Menejment
- 08.00.14 – Iqtisodiyotda axborot tizimlari va texnologiyalari
- 08.00.15 – Tadbirkorlik va kichik biznes iqtisodiyoti
- 08.00.16 – Raqamli iqtisodiyot va xalqaro raqamli integratsiya
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# MUNDARIJA

KORXONALARDA ICHKI AUDIT TIZIMINING BOSHQARUV QARORLARI QABUL QILISHDAGI O'RNINI .....	24
<b>Mexmonaliyev Ulug'bek Erkinjon o'g'li</b>	
FISKAL SIYOSAT SAMARADORLIGI VA SOLIQ TUSHUMLARI DINAMIKASI: O'ZBEKISTON MISOLIDA ILMIY TAHLIL .....	30
<b>Abduraimova Nigora Abdugapparovna</b>	
YASHIRIN IQTISODIYOTNI KELTIRIB CHIQUARUVCHI ASOSIY OMILLAR HAMDA IQTISODIYOTGA TA'SIRI .....	37
<b>Toxtabayev Oybek Odilovich</b>	
QISHLOQ XO'JALIGI OZIQ-OVQAT SANOATI KORXONALARIDA ZAMONAVIY BOSHQARUV .....	42
<b>Rasulova Muxabbat Teshabayevna, Normurodov Sarvar Norboy o'g'li</b>	
O'ZBEKISTON GLOBAL-IQTISODIY RAQOBATBARDOSHLIGINI OSHIRISHDA RAQAMLI IQTISODIYOTNING O'RNINI .....	48
<b>Kuvatova Oliya Sheraliyevna</b>	
QURILISH SANOATIDA KICHIK BIZNES SUBYEKTLARINING IQTISODIY MOHIYATI VA ULARNI KAPITAL BOZORI INSTRUMENTLARI ORQALI MOLIALASHTIRISH IMKONIYATLARI.....	54
<b>Igitov Jurabek Kuzibekovich</b>	
IQTISODIY ISLOHOTLAR DAVRIDA TIJORAT BANKLARINING INVESTITSIYA FAOLIYATINI RIVOJLANTIRISHNING OMILLARI .....	61
<b>Yangiboyev F.B.</b>	
TIJORAT BANKLARIDA MUAMMOLI KREDITLARNI ERTA ANIQLASH VA BOSHQARISHNING INTEGRATSIYALASHGAN RISK-INDEKS MODELINI .....	68
<b>Kalandarov Abdulla Baxtiyorovich, Rajabov Shoxrux Suvon o'g'li</b>	
RUX VA QO'RG'OSHINNI SELEKTIV AJRATIB OLISHNI KOMBINATSIYALASH TEXNOLOGIYASI VA NAZARIYASI.....	74
<b>Eshonqulov Uchqun Xudaynazar o'g'li, Haqberdiyev Dilshod Qodir o'g'li</b>	
UY-JOY QURILISHI HAJMINI UZOQ MUDDATLI PROGNOZLASHDA EKONOMETRIK MODELLASHTIRISH USULLARINI TAKOMILLASHTIRISH .....	81
<b>Qidirniyazov Ajiniyaz Sherniyazovich</b>	
O'ZBEKISTONDA BOG'DORCHILIKNI RIVOJLANTIRISHDA IQLIM VA TABIIY OFATLAR NATIJASIDA YETKAZILDAN TALOFATLARNI DAVLAT TOMONIDAN KOMPENSATSIYA QILISH MEKANIZMI.....	85
<b>Sattorov Orifjon Boymurodovich</b>	
AHOLI MOLIVAVIY SAVODXONLIGINI OSHIRISH ORQALI YASHIRIN IQTISODIYOTNI QISQARTIRISH MEKANIZMLARI.....	90
<b>Abdug'aniyev Uchqun Habibulla o'g'li</b>	
O'ZBEKISTON QURILISH SANOATIDA KICHIK BIZNES SUBYEKTLARINING RIVOJLANISH DINAMIKASI VA TENDENSIYALARI .....	96
<b>Musaeva Aynura Abayxolievna</b>	
THEORETICAL AND METHODOLOGICAL FOUNDATIONS OF SOCIAL INFRASTRUCTURE TRANSFORMATION IN THE CONTEMPORARY ENVIRONMENT.....	104
<b>Normurodov Khusan Eshmakhmatovich</b>	
AKSIYADORLIK JAMIYATLARINING INVESTITSION FAOLLIGINI BAHOLASH YO'LLARI .....	108
<b>Begamov S.X.</b>	
DEBITORLIK QARZLARINING STRATEGIK BOSHQARUV HISOBINI TASHKIL QILISH YO'NALISHLARI .....	112
<b>Normatova Gulmira Xayrullaevna</b>	



SOLIQLARNI PROGNOZLASH METODOLOGIYASINI TAKOMILLASHTIRISH AMALIYOTI TAHLILI.....	118
<b>Ergashov Jamshid Ashurovich</b>	
MEHNAT XARAJATLARI HISOB: NAZARIY ASOSLAR, USULLAR VA BOSHQARUVDAGI AHAMIYATI.....	126
<b>Tulyaganov Abdumalik Abdiraximovich</b>	
KORPORATIV XIZMATLARNING BANK FOYDASIGA TA'SIRI: KOMISSION VA FOIZLI DAROMADLAR TAHLILI .....	131
<b>Qurbonov Abror Abdullayevich</b>	
TIJORAT BANKLARIDA MUAMMOLI KREDITLARNI BOSHQARISH TIZIMINI TAKOMILLASHTIRISHNING INSTITUTSIONAL VA TASHKILY MEXANIZMLARI.....	136
<b>Djamalov G'ofir Oribjanovich</b>	
OCHIQLIK INDEKSI VA KORRUPSIYAGA QARSHI KURASH SAMARADORLIGI: O'ZBEKISTON TAJRIBASINING INSTITUTSIONAL TAHLILI .....	144
<b>Diilshod Pulatov, Uchqun Abdug'aniyev</b>	
DUNYO SUG'URTA KOMPANIYALARINING MOLIVAVIY HOLATI VA NATIJALARI TAHLILI.....	153
<b>Alimov Baxodir Batirovich</b>	
QISHLOQ HUDUDLARIDA XIZMAT KO'RSATISH SAMARADORLIGINI OSHIRISH IMKONIYATLARI.....	160
<b>Yuldashova Nilufar Ziyabayevna</b>	
QURILISH TASHKILOTLARIDA BOSHQARUV SAMARADORLIGINI OSHIRISHNING INNOVATSION USULLARI .....	164
<b>Muxibova Guli Yarkinovna, Sharifxodjayeva Odina Ulug'bek qizi</b>	
AXBOROT-RESURS MARKAZLARINING TA'LIM JARAYONIGA TA'SIRINI BAHOLASH.....	168
<b>Pirmedova Xayitgul Muxammedovna</b>	
IJTIMOYIY HIMOYA QAMROVINI KENGAYTIRISH MEXANIZMLARI: XALQARO TAJRIBA VA INSTITUSIONAL YONDASHUVLAR.....	173
<b>Bafoyev Farrux Jo'raqulovich</b>	
KORXONALARDA AI-DRIVEN "DECISION SUPPORT SYSTEMS" (DSS)NI JORIY ETISHNING KONSEPTUAL ASOSLARI .....	181
<b>Mardanova Ra'no</b>	
STRENGTHENING THE FINANCING OF FAMILY-OWNED ENTERPRISES IN UZBEKISTAN THROUGH BANK CREDIT .....	186
<b>Baymuratova Zina Aqilbekovna, Ibadullaeva Asal Ulugbek qizi</b>	
SUN'IY INTELLEKT ASOSIDA DAVLAT BOSHQARUV TIZIMLARINI RAQAMLASHTIRISH .....	192
<b>Aytmuratov Qutlimurat Jalgasovich</b>	
ATTRACTING INVESTMENTS FROM FINANCIAL MARKETS AND FACTORS INFLUENCING THE INCREASE OF THEIR ATTRACTIVENESS .....	196
<b>Kholov Sherali Akhrorboyevich</b>	
MARKAZIY OSIYODA TRANSCHEGARAVIY SUV RESURSLARINI BOSHQARISH VA ADOLATLI TAQSIMLASHNING NAZARIY-HUQUQIY ASOSLARI.....	200
<b>Matkarimov Mansur</b>	
XALQARO XIZMATLAR SAVDOSIDA TIBBIY TURIZMNING IQTISODIY AHAMIYATI.....	206
<b>Farxodova Shohnoz Umidbek qizi</b>	
BANK XIZMATLARI SIFATINI BAHOLASHNING KO'P OMILLI INDIKATORLARI TIZIMI .....	213
<b>Ibroximov Iloxomjon Shavkatjon o'g'li</b>	
SANOAT KORXONALARINI IQTISODIY FAOLIYATINI OPTIMALLASHTIRISH YO'LLARI .....	219
<b>Tillayeva Barno Ramiztdinovna</b>	
NOTIJORAT TASHKILOTLAR FAOLIYATIDA AUDITORLIK TEKSHIRUVI VA AUDITORLIK HISOBOTLARINING O'ZIGA XOSLIGI.....	224
<b>Xolmirzayev Ulug'bek Abdulazizovich, Ubaydullayev Toxirjon Abdullajanovich</b>	



ЦИФРОВЫЕ ИНСТРУМЕНТЫ РЕИНТЕГРАЦИИ ВОЗВРАЩАЮЩИХСЯ ТРУДОВЫХ МИГРАНТОВ: МЕЖДУНАРОДНАЯ ПРАКТИКА И ВОЗМОЖНОСТИ ДЛЯ КЫРГЫЗСТАНА.....	230
<i>Амантурова Дилбара Кыдыкбековна</i>	
РОЛЬ ПРОФЕССИОНАЛЬНО-ОРИЕНТИРОВАННОЙ ЛЕКСИКИ В ЯЗЫКОВОЙ ПОДГОТОВКЕ ИНОСТРАННЫХ СТУДЕНТОВ ТЕХНИЧЕСКОГО ПРОФИЛЯ.....	237
<i>Асрарова М.У.</i>	
О СКОРИНГОВЫХ МЕТОДАХ ЭКСПРЕСС-АНАЛИЗА ДОХОДНОСТИ АКЦИЙ УЗБЕКСКИХ ЭМИТЕНТОВ.....	242
<i>Ирмухамедова Муслима Дилшодовна</i>	
UY-JOY QURILISHIDA ESKROU MEKANIZMLARINI JORIY ETISH ORQALI INVESTITSION XAVFSIZLIK VA MOLIVAVIY SHAFFOFLIKNI TA'MINLASH .....	247
<i>Karimov Inomjon Ortikbaevich</i>	
YASHIL IQTISODIYOT SHAROITIDA KICHIK BIZNESNING RAQOBATBARDOSHLIGINI OSHIRISH MASALALARI .....	254
<i>Kamoliddinov Ilhomjon Muxammadjonovich, Kobilov Murod Vakkosovich</i>	
TIJORAT BANKLARI RAQOBATBARDOSHLIGINING MOLIVAVIY BARQARORLIK KO'RSATKICHLARIGA TA'SIRINI BAHOLASH.....	259
<i>Axmedov Toxirjon Xasanjon o'g'li</i>	
SANOAT KORXONALARI IQTISODIY XAVFSIZLIGINI TA'MINLASHDA ENERGETIKA VA ISHLAB CHIQARISH SALOHİYATINING ROLI .....	264
<i>Tursunxo'jayev Sardor Jamoliddin o'g'li</i>	
TIJORAT BANKLARIDA KOMPLAENS-NAZORAT TIZIMI ORQALI RISKLARNI SAMARALI BOSHQARISH .....	270
<i>Fayziyev Sherzod Djunaydilloyevich</i>	
СОВЕРШЕНСТВОВАНИЕ УПРАВЛЕНИЯ БАНКОВСКИМИ РИСКАМИ И СТРАХОВАНИЯ ФИНАНСОВЫХ ОПЕРАЦИЙ В УСЛОВИЯХ РАЗВИТИЯ ДИСТАНЦИОННОГО БАНКИНГА В ХОРЕЗМСКОЙ ОБЛАСТИ.....	275
<i>Бахтиёров Худайберган Хамдам угли</i>	
DOIMIY BO'LMAGAN KUCH TA'SIRIDA DEFORMATSIYALANUVCHAN STANDART CHIZIQLI QATTIQ MODEL ISHLAB CHIQISH VA SONLI TAHLIL QILISH.....	282
<i>Ahmadov Ilhom Aktam o'g'li, Isomova Sabohat Islom qizi</i>	
YOUTH ENTREPRENEURSHIP AS A FACTOR OF STRUCTURAL ECONOMIC TRANSFORMATION IN UZBEKISTAN.....	290
<i>Isakjanova Saboxat Muhamedovna</i>	
МОДЕЛИРОВАНИЕ САМОВОЗБУЖДЕНИЕ НЕЯВНОПОЛЮСНОГО СИНХРОННОГО ГЕНЕРАТОРА ПРОДОЛЬНО-ПОПЕРЕЧНОГО ВОЗБУЖДЕНИЯ .....	298
<i>Пирматов Нурали Бердиёрович, Бекишев Аллаберген Ергашевич, Бердиёров Улугбек Нурали угли, Бердиёров Улмасбек Нурали угли</i>	
YURTIMIZDAGI EKOLOGIK SOF YOG'OCH MATERIALLARIDAN TAYYORLANGAN ORAYOMA KONSTRUKSIYALARINING CHO'ZILISHGA QARSHILIGI .....	305
<i>Yunusaliyev Elmurod Muhammadyaqubovich, Toshpulatov Ilhomjon Baxtiyorovich</i>	
AYDAR-ARNASOY KO'LLAR TIZIMINING SHAKLLANISH BOSQICHLARI VA ZAMONAVIY EKOLOGIK MUAMMOLARI .....	311
<i>Aminov Hamza Husanovich, Madrimov Rajabboy Masharipovich, Xamdullayeva Aziza Baxtiyor qizi</i>	
EXPLAINABLE AI YORDAMIDA SOC UCHUN TUSHUNTIRILADIGAN KIBERXAVF ANIQLASH TIZIMINI ISHLAB CHIQISH .....	318
<i>N.N. Jo'rayev, A.Sh. Juraboyev</i>	
QUYOSH FOTOELEKTRIK MODULLARINI SUV YORDAMIDA TOZALASH VA SOVITISH USULLARI TAHLILI .....	324
<i>Ibragimov Umidjon Hikmatullayevich, Qodirov Jobir Ro'zimatovich, Izomov Shahzod Niyoz o'g'li, To'ymurodov Quvonchbek Sherzod o'g'li</i>	



RAQAMLI TEXNOLOGIYALARNING QURILISH SOHASIGA INTEGRATSIYASI: ILG'OR XALQARO TAJRIBA .....	332
<b>Fayziyeva Gulnoza Abdurahmonovna</b>	
ФАКТОРЫ НАЛОГОВОЙ КУЛЬТУРЫ И ИХ ВЛИЯНИЕ НА СОБИРАЕМОСТЬ НАЛОГОВ: СОЦИОЛОГИЧЕСКИЙ И ЭКОНОМИЧЕСКИЙ АНАЛИЗ .....	339
<b>Хакимова Ситора Ильёсжон кизи, Муталова Дилором Махамаджановна</b>	
ИННОВАЦИОННЫЕ МЕТОДЫ ЭКСПЕРТНОГО ПРОГНОЗИРОВАНИЯ КОМПЕТЕНЦИЙ В ЦИФРОВОЙ ЭКОНОМИКЕ .....	345
<b>Л.А. Кадырова, Б. Н. Эгамов</b>	
О'ZBEKISTON RESPUBLIKASIDA SUG'URTA BOZORINING TUZILISHI TAHLILI .....	350
<b>G'oziyeva Aziza Abdusalomovna</b>	
MINTAQALARDA INNOVATSION FAOLIYATNI MOLIYALASHTIRISH MANBALARINI DIVERSIFIKATSIYA QILISH MASALALARI .....	358
<b>Xamrayev Quvvat Iskandarovich</b>	
KONTEYNERLI TASHUVLARNING JORIY HOLATI, MAVJUD MUAMMOLAR VA RIVOJLANTIRISH ISTIQBOLLARI .....	366
<b>Samatov G'affor Alloqulovich, Xolmatov Bekzod Nurmatovich, Toxirov Maxmudjon Murodjon o'g'li, Absattarov Isomiddin Xotam o'g'li</b>	
KICHIK BIZNES KORXONALARIDA ISHLAB CHIQRISH OMILLARI BO'YICHA NOMUVOFIQLIKNI ANIQLASH VA BARTARAF ETISH MEKANIZMI .....	381
<b>Kaypnazarova Gulshad Xojamuratovna</b>	
TASHQI SAVDO BALANSINI MUVOZANATLASHTIRISH: NAZARIY VA AMALIY JIHATLAR .....	386
<b>Rahimov Eshmurod Normurodovich, Misliiddinov Ikromjon Kamoliddin o'g'li</b>	
SIFATLI TIBBIY XIZMAT KO'RSATISH VA AHOLIGA QAMROVNI TA'MINLASHDA BOSHQARUV QARORLARINING AHAMIYATI .....	391
<b>Satvoldiyev Ulugbek Kamilovich</b>	
SUN'IY INTELLEKT TIZIMLARIDA GIPERPARAMETRLARNI MATEMATIK OPTIMALLASHTIRISH USULLARI .....	396
<b>Husan Arziqulov Normurod o'g'li</b>	
ENHANCING THE SERVICE SECTOR AS A MEANS OF CREATING EMPLOYMENT IN TOURISM INFRASTRUCTURE .....	401
<b>Zarikeev Rasul Polatovich</b>	
EXPANDING BANK CREDIT OPPORTUNITIES FOR FAMILY-OWNED ENTERPRISES IN UZBEKISTAN .....	406
<b>Isakov Janabay Yakipbaevich</b>	
BANKS' BROKERAGE AND ADVISORY SERVICES IN FACILITATING SECURITIES TRANSACTIONS AND IMPROVING MARKET LIQUIDITY .....	412
<b>Isakov Isobek Janabay uli</b>	
АКТУАЛЬНЫЕ ПРОБЛЕМЫ РАЗВИТИЯ МЕХАНИЗМОВ ФИНАНСИРОВАНИЯ ВНЕШНЕЙ ТОРГОВЛИ .....	416
<b>Ибрагимов Мансур Ахметович</b>	
ОПТИМИЗАЦИЯ ДЕЯТЕЛЬНОСТИ ЛОГИСТИЧЕСКИХ ПРОВАЙДЕРОВ В УСЛОВИЯХ ПОСТРОЕНИЯ НОВЫХ ЦЕПЕЙ ПОСТАВОК .....	421
<b>Маннапова Феруза Фахриддин кызы</b>	
О'ZBEKISTON RESPUBLIKASIDA ISLOM MOLIYASINI HUQUQIY TARTIBGA SOLISH VA INSTITUSIONAL ASOSLARINI TAKOMILLASHTIRISH MASALALARI .....	428
<b>Isroilov Obid Olimjonovich</b>	
OZIQ-OVQAT BOZORI KON'YUNKTURASINI BAHOLASHDA KO'P OMILLI REGRESSIYA MODELINING SAMARADORLIGI .....	433
<b>Abduraxmonov Adxamjon Sultonboyevich</b>	



AHOLI TURMUSH TARZINI YAXSHILASHNING ISTIQBOLLARI.....	438
<b>Djuraeva Didora Sobirjonovna</b>	
ZAMONAVIY MOLIYAVIY INFRATUZILMANING INSTITUSIONAL ASOSLARI: TO'LOV TIZIMLARI NAZARIYASI VA O'ZBEKISTON AMALIYOTI .....	441
<b>Toshniyozov Sherali Kamoliddinovich</b>	
XIZMAT KO'RSATISH KORXONALARIDA RAQAMLI MENEJMENT VA SUN'IY INTELLEKT ASOSIDA STRATEGIK BOSHQARUVNI TAKOMILLASHTIRISH .....	449
<b>Zayavitdinova Nafisa Muxammadovna</b>	
CORPORATE GOVERNANCE, FDI, AND URBANIZATION IN THE GREEN ECONOMIC TRANSFORMATION OF UZBEKISTAN .....	454
<b>Ablaeva Valentina</b>	
FEMALE ENTREPRENEURSHIP AND MICRO-ENTERPRISE DEVELOPMENT .....	460
<b>Dilafroz Kuchkorova</b>	
LEGIRLANGAN PO'LATLARDAN TAYYORLANGAN PROKATLASH JO'VALARINI CHIDAMLILIGINI OSHIRISH UCHUN TERMIK PUXTALASH TEXNOLOGIYALARINI TAKOMILLASHTIRISH.....	466
<b>Saydumarov Botir Muradovich, Berdiyev Darob Murotovich, Tashmatov Ravshan Qobilovich</b>	
SHAMOL TURBINASINING IKKI TOMONLAMA TA'MINLANADIGAN ASINXRON GENERATORI O'TKINCHI JARAYONLARINING TAHLILI .....	471
<b>Bekishev Allabergen Yergashevich, Kurbonov Najmiddin Abduxamidovich, Yunusov Obidxon Abdivait o'g'li, Jo'rayev Doston Majid o'g'li</b>	
TIJORAT BANKLAR FAOLIYATI SAMARADORLIGINI OSHIRISHGA TA'SIR QILUVCHI OMILLAR TAHLILI.....	479
<b>Babaxanova Dildora Rustamovna</b>	
RAQOBAT USTUNLIGIGA ERISHISHDA ZAMONAVIY MARKETING TEXNOLOGIYALARINI QO'LLASH .....	485
<b>Meliqulov Abduhalil Norinovich</b>	
JAMOAT AHAMIYATIGA EGA TASHKILOTLAR TOIFASIGA KIRITISH MEZONLARI, ULARNING MOLIYAVIY HISOBOTLARI VA AUDITIGA QO'YILADIGAN TALABLAR.....	490
<b>Shodiyev Murodjon Bakirovich</b>	
EFFICIENCY OF IMPROVING THE IT SERVICES EXPORT .....	494
<b>Uzakov Ortik Shaymardanovich</b>	
CHORVACHILIKDA ILK VETERINARIYA XIZMATI TARIXI: QADIMGI O'ZBEKISTON MISOLIDA.....	499
<b>Sayfudinova Djamila Badridinovna</b>	
AHOLINI IJTIMOYIY HIMOYALASH TIZIMINI BOSHQARISHGA BAG'ISHLANGAN DASTLABKI ILMIY QARASHLARNING SHAKLLANISHI VA ULARNING TAHLILI .....	503
<b>Xamroyev Anvar Ashurovich</b>	
AHOLINING MOLIYAVIY SAVODXONLIGINI RIVOJLANTIRISH OMILLARI HAMDA MOLIYAVIY TEXNOLOGIYALARDAN FOYDALANISHNING IQTISODIY AFZALLIKLARI.....	508
<b>A.A.Abdvoxidov</b>	
NODAVLAT OLIY TA'LIM MUASSASALARINING MOLIYAVIY HOLATINI KOMPLEKS BAHOLASH VA IQTISODIY SAMARADORLIGINI TAHLIL QILISH .....	518
<b>Turmanqulov Norpo'lat Sa'dullayevich</b>	
PERFORMANCE APPRAISAL FAIRNESS AND EMPLOYEE OUTCOMES IN UZBEKISTAN'S EDUCATIONAL INSTITUTIONS: A QUANTITATIVE INVESTIGATION .....	525
<b>Farida Nishanova</b>	
SANOAT KORXONALARIDA SIFAT BOSHQARUVI TIZIMLARINING ISHLAB CHIQRISH JARAYONIGA TA'SIRI .....	535
<b>O'.M. Baytanov</b>	



DIGITAL METHODS FOR MONITORING HAND HYGIENE AND AUTOMATIC NAIL SEGMENTATION USING COMPUTER VISION TECHNOLOGIES .....	540
<b>Shavkat Shukhratovich Azimov, Temurbek Zokir Ugli Daminov, Durdona Nurjonovna Rasulova, Dilorom Umrzakovna Nalibaeva</b>	
MATLAB-BASED OPTIMIZATION OF METHANE FEED INTAKE IN A GTL PLANT FOR SYNTHETIC FUEL PRODUCTION.....	545
<b>U.T. Beshimov, U.R. Azamatov, A.G. Makhsumov, E.E. Mashaev</b>	
НЕОБХОДИМОСТЬ ОБЕСПЕЧЕНИЯ ОПТИМАЛЬНОГО ИНВЕСТИЦИОННОГО ВЛОЖЕНИЯ В СОЦИАЛЬНО-ЗНАЧИМЫХ ИННОВАЦИОННЫХ ПРЕДПРИЯТИЯХ .....	554
<b>Зайналов Ж.П. , Абдуллаева С.Ш., Нурмухамедов А.М.</b>	
INFORMATIKA FANINI O'QITISHDA ONLAYN TEST VA AVTOMATIK BAHOLASH TIZIMLARI: INNOVATSION METODLAR, ZAMONAVIY YONDASHUVLAR VA DOLZARB MUAMMOLAR TAHLILI.....	561
<b>Nasriddinov Zaynobiddin Xusniddin o'g'li, Sayidov Nozimjon Abdulnosirovich</b>	
SERVOMOTORLARNING XARAKTERISTIKALARI .....	565
<b>Pirmatov Nurali Berdiyarovich, Egamov Akmal Mamarasulovich, Mamarasulov Nodir Akmal o'g'li</b>	
XIZMAT KO'RSATISH SOHASINI BOSHQARISHNING TASHKILY-IQTISODIY MEXANIZMLARINI TAKOMILLASHTIRISH.....	572
<b>O'rinov Komiljon Kozimovich</b>	
MAISHIY XIZMAT KO'RSATISHDA SIFAT NAZORATINI OSHIRISHNI RAQAMLASHTIRISH YO'LLARI.....	576
<b>Meliyev X.T.</b>	
INVESTIGATION OF THE EFFICIENCY OF FATS AND OILS REMOVAL FROM WASTEWATER GENERATED BY PUBLIC CATERING ENTERPRISES .....	585
<b>Durdona Obutjonova, Xayrullo Ibroximov, Ahmadjon Ibadullaev, Umar Chorshanbiev, Babaev Askar</b>	



# INVESTIGATION OF THE EFFICIENCY OF FATS AND OILS REMOVAL FROM WASTEWATER GENERATED BY PUBLIC CATERING ENTERPRISES

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**Abstract.** This article presents a comprehensive analysis of the sources of wastewater generation in public catering enterprises and the mechanisms of their contamination. It is substantiated that high concentrations of fats and oils accumulate in wastewater as a result of kitchen processes, dishwashing, and sanitary–hygienic activities. Based on scientific literature, the negative impact of fatty substances on the operation of sewerage systems through processes such as emulsification, saponification, and mechanical mixing is analyzed. A review of the literature also summarizes the typical ranges of biochemical oxygen demand (BOD), chemical oxygen demand (COD), suspended solids, and fat concentrations in wastewater generated by public catering facilities. The results of the study provide a scientific basis for the technological and environmental feasibility of using grease traps and contribute to ensuring the reliable and stable operation of sewerage systems.

**Keywords:** Public catering enterprises, wastewater, fats and oils, emulsification, saponification, BOD, COD, grease trap.

**Annotatsiya.** Ushbu maqolada umumiy ovqatlanish korxonalarida hosil bo'ladigan oqova suvlarning shakllanish manbalari hamda ularning ifloslanish mexanizmlari kompleks tahlil qilingan. Oshxona jarayonlari, idish-tovoq yuvish va sanitariya-gigiyena ishlari natijasida oqova suv tarkibida yog'-moy moddalarining yuqori konsentratsiyalarda to'planishi asoslab berilgan. Yog' moddalarning emulsifikatsiya, saponifikatsiya va mexanik aralashish jarayonlari orqali kanalizatsiya tizimlarining ishlashiga salbiy ta'sir ko'rsatishi ilmiy manbalar asosida tahlil qilingan. Adabiyotlar tahlili asosida oqova suvlarning kislorodga bo'lgan biokimyoviy ehtiyoj, kislorodga bo'lgan kimyoviy ehtiyoj, suspenziya moddalar hamda yog' moddalari konsentratsiyalarining tipik oraliq qiymatlari umumlashtirilgan. Tadqiqot natijalari yog' tutgichlardan foydalanishning texnologik va ekologik jihatdan maqsadga muvofiqligini asoslashga, shuningdek, kanalizatsiya tizimlarining ishonchli va barqaror ishlashini ta'minlashga xizmat qiladi.

**Kalit so'zlar:** Umumiy ovqatlanish korxonalar, oqova suvlar, yog' moddalari, emulsifikatsiya, saponifikatsiya, KBE, KKE, yog' tutgich.

**Аннотация.** В данной статье представлен комплексный анализ источников образования сточных вод на предприятиях общественного питания и механизмов их загрязнения. Обосновано, что в результате кухонных процессов, мытья посуды и санитарно-гигиенических работ в составе сточных вод накапливаются высокие концентрации жиров и масел. На основе научной литературы проанализировано отрицательное влияние жировых веществ на работу канализационных систем через такие процессы, как эмульгирование, омыление (сапонификация) и механическое перемешивание. В ходе анализа литературных источников также обобщены типичные диапазоны значений биохимической потребности в кислороде (БПК), химической потребности в кислороде (ХПК), взвешенных веществ и концентрации жиров в сточных водах, образующихся на предприятиях общественного питания. Результаты исследования служат научным обоснованием технологической и экологической целесообразности использования жиросъемщиков и способствуют обеспечению надежной и стабильной работы канализационных систем.

**Ключевые слова:** предприятия общественного питания, сточные воды, жиры и масла, эмульгирование, сапонификация, БПК, ХПК, жиросъемщик.

## INTRODUCTION

Currently, the processes of urbanization and the increasing number of public catering establishments are intensifying problems related to wastewater generation. In particular, the discharge of fats and oils into sewerage systems leads to pipe blockages, emergency situations, and environmental pollution. Therefore, studying the mechanisms of wastewater formation in public catering facilities is considered an important scientific and practical task. The purpose of this study is to analyze the sources and contamination mechanisms of wastewater generated in public catering enterprises and to assess the impact of fatty substances on sewerage systems.

Based on the research objectives and the relevance of the problem, the following tasks were defined:

- to identify the sources of wastewater generation in public catering enterprises;
- to analyze the mechanisms of emulsification, saponification, and mechanical mixing of fatty substances;
- to evaluate the physicochemical characteristics of wastewater (BOD, COD, FOG, TSS) based on literature data;
- to provide a scientific justification for the necessity of using grease traps.

Wastewater generated in public catering facilities (such as restaurants, cafeterias, barbecue restaurants, and other service establishments) has a significant environmental impact on a global scale. Analyses conducted in different countries show that the physicochemical parameters of such wastewater are considerably higher than those of typical municipal wastewater, which creates an additional load on sewerage systems.

## LITERATURE REVIEW

International studies have reported that wastewater samples collected from public catering establishments exhibit extremely high oxidation indices [1]. In particular, the chemical oxygen demand (COD) in such wastewater has been recorded at levels reaching up to 9,948 mg/L, while the biochemical oxygen demand (BOD) may increase to approximately 3,170 mg/L, which is significantly higher than the values typically observed in conventional municipal wastewater [2-3].

In addition, the concentration of fats, oils, and grease (FOG) is also relatively high. In several studies, FOG concentrations in wastewater from food service facilities have been reported to reach up to 1,640 mg/L. These elevated levels are mainly associated with cooking processes, dishwashing activities, and the discharge of food residues into drainage systems. Such international statistical data clearly demonstrate that wastewater generated by public catering enterprises is characterized by a high physicochemical load, which can negatively affect the operation of sewerage systems [4]. High concentrations of organic matter and fatty substances contribute to the formation of blockages, deposits, and operational failures within sewer pipelines. Therefore, many researchers emphasize the importance of implementing effective technological solutions and preliminary wastewater treatment methods in public catering facilities. In particular, the installation of grease traps and other pre-treatment systems is considered one of the most efficient approaches for reducing the concentration of fats and oils before wastewater enters the municipal sewer network [5-9]. The application of such technologies not only improves the reliability of sewerage infrastructure but also reduces the environmental impact of wastewater discharges.



## RESEARCH METHODOLOGY

The object of this study was wastewater generated in public catering enterprises located in the city of Tashkent. The research employed methods of systematic analysis, comparison, and generalization to examine the characteristics and sources of wastewater contamination in such facilities. In assessing the main pollution mechanisms of wastewater, particular attention was given to the theoretical analysis of processes such as mechanical mixing, emulsification, saponification, and hydrolysis. These processes play a significant role in the formation and stabilization of fats, oils, and grease (FOG) in wastewater produced during cooking, dishwashing, and other sanitary activities in food service establishments. The operating principle of grease traps and their role in protecting sewerage systems from the adverse effects of fatty substances were evaluated based on existing regulatory documents and relevant scientific literature. Special emphasis was placed on the technological and environmental importance of grease traps in preventing pipe blockages and improving the reliability of urban sewerage systems. The physicochemical characteristics of wastewater were evaluated in accordance with the requirements of current standards for water quality assessment. In particular, the study considered the provisions of GOST 31861 and GOST 31957, as well as other relevant GOST and O'zDSt regulatory standards related to the determination of suspended solids and fats, oils, and grease concentrations in wastewater. These standards provided the methodological basis for assessing the main indicators of wastewater quality and pollution levels in public catering facilities.

**Analysis and Results.** The results of the conducted research indicate that the largest proportion of wastewater (approximately 50–60%) generated in public catering enterprises originates from kitchen activities. During food preparation processes, both animal-based products (such as meat and dairy products) and plant-based substances (vegetable oils and fats) enter the wastewater stream. During frying, boiling, and cooking processes, fatty substances remain in a liquid state at high temperatures and can easily enter the drainage system. However, when the temperature decreases, these substances solidify and form deposits inside sewer pipes, contributing to blockages and operational problems.

During the dishwashing process (either manually or using dishwashers), the combined effects of detergents and hot water cause fat particles to transform into fine emulsions. Dishwashing machines further break down fat particles, with approximately 40–50% of the particles having sizes smaller than 45 micrometers. As a result, these particles cannot be completely separated by conventional grease traps, leading to the formation and accumulation of grease deposits in sewer systems [5].

In addition, floor and equipment cleaning activities contribute to wastewater pollution. During these processes, food residues, fats, and detergents mix with water, thereby increasing the organic load of the wastewater. Sanitary activities (such as toilet use and washing) account for the remaining portion of water consumption in such facilities. The distribution of wastewater sources in public catering enterprises is presented in Table 1.

**Table 1. The content of fats and oils in wastewater from public catering establishments**

The type of the feeding point	FOG concentration, mg/l	Description
the small cafes and choyxona	150 – 400	is formed as a result of the preparation of light meals and wash utensils Basically
the average of the restaurants	300 – 800	Roasting, the cooking process the effects and the container of the washing machine large
fast-food in the kitchen and on the frityur	600 – 1500	Roasting used a lot of oils, oil of the downloads at the top,
large kitchen (kant, the production of the kitchen)	400 – 1200	large size of Meals, intensive washing process
as noted in the international literature, the maximum value	is 100 – 1640	tracked in the research of some extreme cases

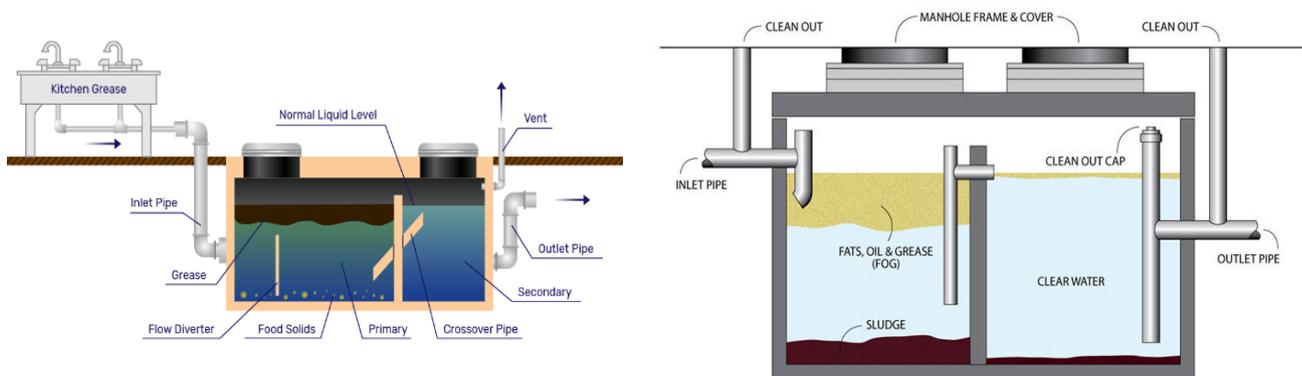
The presence of high concentrations of fats, oils, and grease (FOG) in wastewater generated from public catering establishments leads to increased hydraulic resistance in sewerage networks, narrowing of pipe cross-sections, and a decrease in operational reliability.



Picture 1. The effect of oil and oil waste on pipes

In this regard, utilizing local mechanical treatment units, specifically grease traps, before discharging wastewater from such facilities into the centralized sewerage system is a technologically and sanitarly justified solution. Grease traps are mechanical treatment devices designed to separate fats, oils, and grease from wastewater; their operation is primarily based on the density difference between liquid phases and the process of gravitational separation [6-7]. Since the density of oils and fats is lower than that of water, oil droplets rise to the upper layer under stabilized hydraulic flow conditions, while relatively heavy mechanical particles form a sediment at the bottom of the unit. Consequently, relatively clarified water is discharged from the middle layer of the separation zone [10-11].

Scheme of operation of oil holders. The effluent is fed into the device with reduced flow rate in the inlet chamber; in the separation zone, the grease-grease accumulates in the upper part as a Floating layer, while mechanical impurities are collected in the bottom in the form of sediment; using special hydraulic barriers, relatively purified water is directed to the outlet pipe and transmitted to the next sewer network. The fat layers and sediments accumulated inside the device are periodically removed in accordance with the established (pic. 2).



Picture 2. Working pallets of oil holders

In the design of oil holders, their geometric dimensions and technological indicators were determined on the basis of wastewater consumption, concentration of pollutants and hydraulic conditions of the separation process. As the main calculation parameter, the calculation consumption of running water passing through the device was adopted:

$$Q = \sum_{i=1}^n q_i \quad (1)$$

here:

$Q$ — total wastewater consumption ( $\text{m}^3/\text{s}$  or  $\text{l/s}$ );  $q_i$ — water consumption of individual sources (washing baths, dishwashers, etc.). For the effective separation of oil drops, the effluent is required to be in a relatively calm state within the device for a certain period of time. This stagnation (or hydraulic capture) time  $t$  in practice is usually taken at intervals of 15-30 minutes. On this basis, the minimum working volume of the oil holder was determined by the following expression:

$$V = Q \cdot t \quad (2)$$



$V$  — working volume of oil holder ( $m^3$ );  $Q$  — effluent consumption ( $m^3/s$ );  $t$  — hydraulic capture time (s).

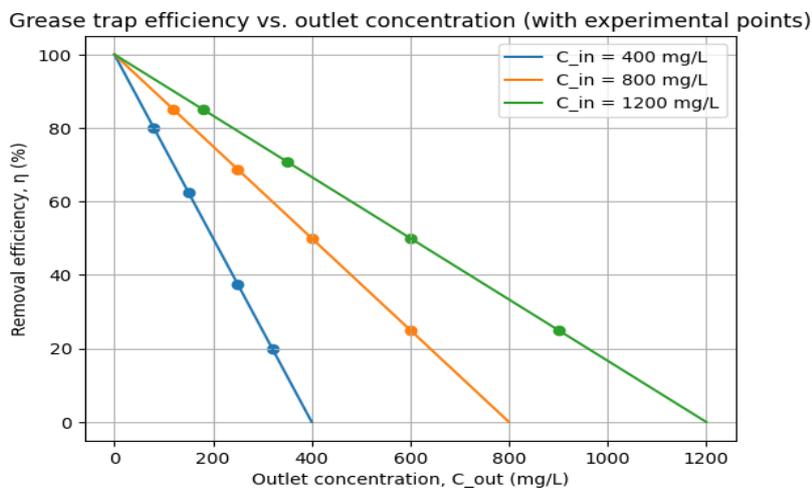
This relationship serves to reduce the flow rate in the device and provide the necessary conditions for the float of oil drops. In practice, the constructive volume of the device is assumed large from the calculated value with a certain reserve coefficient, which makes it possible to take into account the change in the load during the operation process.

The performance of the oil holder, i.e. the oil-to-oil retention rate, was assessed by comparing the concentrations in the input and output current. The cleaning efficiency was determined by the following formula:

$$\eta = \frac{C_{in} - C_{out}}{C_{in}} \times 100\% \quad (3)$$

here:  $C_{in}$  — concentration of fatty-fatty substances in the entrance to the oil holder (mg/L),  $C_{out}$  — concentration of fatty-fatty substances at the exit from the oil holder (mg/L),  $\eta$  — cleaning efficiency, %.

This indicator is the main criterion in assessing the technological efficiency of the oil holder. Practical observations show that in ordinary gravitational oil holders, the value of  $\eta$  is usually in the range of 60-85%, while in devices equipped with lamellar or coalescent elements, this indicator can reach 80-95% (pic.3).



Picture 3. Oil holder efficiency

The cleaning efficiency of the graphic oil holder shows the dependence of  $\eta$  on the output concentration  $C_{out}$  for different input concentrations ( $C_{in}=400$ ; 800 and 1200 mg/L). In accordance with the numerical links, there is a linear reduction of  $\eta$  with an increase in  $C_{out}$ , which is consistent with the expression (3). The position of the sample experimental points presented in the graph close to the theoretical curves confirms that the process is satisfactorily characterized by the accepted model. The results showed that oil holders could provide efficiency of around 60-90% at input concentrations in the 400-1200 mg/L range, and that their use in pre-treatment of effluent in catering establishments was technologically sound.

In this study, the sources of formation and mechanisms of pollution of wastewater generated from catering enterprises were analyzed, substantiating on the basis of scientific literature and analytical data that the high concentration of fatty-oil substances (fodder) in their composition has a serious negative effect on the reliable operation of sewage systems. Within the framework of the study, it was substantiated that the principle of operation of oil holders is based on the process of gravitational separation, that in their design it is possible to determine the working volume based on wastewater consumption and hydraulic capture time, and that cleaning efficiency (3) can be assessed by expression. The analysis of graphs and sample experimental points built on computational linkages showed that oil holders can operate at input concentrations in the 400-1200 mg/L range with an efficiency of 60-90% and above, depending on the constructive solution.

Conclusion and Recommendations. In this study, the sources of formation and pollution mechanisms of wastewater generated from public catering establishments were analyzed. Based on scientific literature and analytical data, it was substantiated that the high concentration of fats and oils (FOG – fats, oils and grease) in such wastewater can significantly negatively affect the reliable operation of sewerage systems. Within the framework of the research, it was determined that the operating principle of grease traps is based on the process of gravitational separation. It was also established that during the design of grease traps, the required working volume can be determined on the basis of wastewater flow rate and hydraulic retention time, while the



treatment efficiency can be evaluated using expression (3). The analysis of graphs constructed on the basis of calculated relationships and representative experimental data showed that grease traps can operate with an efficiency of 60–90% or higher at influent concentrations in the range of 400–1200 mg/L, depending on their structural configuration. The obtained results indicate that the installation of grease traps in public catering facilities can significantly reduce the load on centralized sewerage networks, prevent pipeline clogging and improve the overall operational reliability of wastewater systems. Therefore, it is recommended to introduce mandatory installation of appropriately sized grease traps at the outlets of catering facilities, along with the optimization of their hydraulic design parameters and regular maintenance schedules to ensure stable and efficient operation.

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