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INNOVATIVE SOLUTIONS FOR DUST CONTROL IN COTTON GINNING ENTERPRISES

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Abstract: The article describes the technological process of primary processing of cotton, which is accompanied by a significant release of dust from technological and transporting machines into production premises and the atmosphere. The norm of air dust content in the production premises of a cotton gin plant is no more than 10 mg/m³. To create normal sanitary and hygienic conditions, production premises and individual dust-emitting installations are dedusted. Before exhaust dust-laden air is released into the atmosphere, it is also cleaned of dust. At the beginning of the technological process, during transportation and cleaning of raw cotton from impurities, mineral dust is mainly released from it and pollutes the air; at the end of the technological process, especially during linting and compaction, dust of organic origin is released. Despite the installation of the necessary dust removal equipment, many problems and unresolved issues remain.

Keywords: Raw cotton, dust removal, equipment, cyclone, workshop, atmosphere, air, rate, dust, fraction, cleaning, dust suction, percentage, result.

Introduction. The dust released from raw cotton consists of organic and mineral fractions. The organic fraction consists of crushed particles of cotton bushes or bolls and a mass of small short fibers. The mineral fraction of dust consists of earth, sand and other waste impurities that are added to raw cotton during harvesting and the period of its transportation and storage.

At the beginning of the technological process, during transportation and cleaning of raw cotton from impurities, mineral dust is mainly released from it and pollutes the air, and at the end of the technological process, especially during linting and compaction, dust of organic origin is released.

The dust content of the air exhausted from technological equipment in production workshops depends on the type, humidity and contamination of raw cotton; when processing raw cotton of low grades, dust emission is most intense; Table 1 shows the approximate composition of dust released with the air during pneumatic transportation of raw cotton (III grade hand-picked, Namangan-77 variety).

Table 1. Disperse composition of dust.

Particle size, μ	0-50	50-70	70-90	90-160	160-190	190-250	250-500	500-1000	1000 or more
The content of particles of a given size in dust, %	3	12	9	5	4	11	12	9	3

Data on the amount and dust content of exhaust air emitted by the main technological equipment are given in Table 2.

The amount and dust content of air emitted from the main process equipment:

Table 2. The amount of air and dust emitted from the main technological machines.

No	Equipment	Amount of air released into the atmosphere, m ³ /s	Air dust content, mg/m ³
1.	Fan of pneumatic conveyor unit	4.5 – 7.0	4000-12000
2.	Battery condenser for two gins	3.2	500-2000
3.	Battery condenser for four gins	6.4	500-1500
4.	Condenser for five linters	5.0	800-2000
	for six linters	6.0	800-2000
	for seven linters	7.0	800-2000

Each dust removal installation of local suction is characterized by a dust retention effect, which is determined by the formula (%):

$$\eta = \frac{G_1}{G_2} \times 100$$

G₁– total mass of dust in the exhaust air;

G₂ – mass of dust retained by the dust removal installation.

The dust retention effect can also be determined by the difference in dust content of the air (mg/m³) entering and exiting the dust collector (%):

Then

$$\eta = \frac{d_1 - d_2}{d_1} \times 100$$

here: d₁ – dustiness of the air entering the dust collector;

d₂ – dustiness of the air leaving the dust collector.

Dust-laden and contaminated air sucked from dust sources, as well as air exhausted in pneumatic conveying installations, must be cleared of dust before it is released into the atmosphere. Cleaning it can be coarse, medium and fine.

During rough cleaning of dusty air, the air is cleared of dust larger than 100 μ; the dust content of the air after such cleaning can be more than 150 mg/m³. During average cleaning, dust with a size of 10 μ and above is released; the dust content of the air after cleaning should not exceed 150 mg/m³. Such air can be released into the atmosphere. During fine cleaning, dust with a size of less than 10 μ is captured, and the residual dust content in the air should not exceed 2-3 mg/m³. To clean dust-laden air before releasing it into the atmosphere, centrifugal dust collectors-cyclones are widely used. Centrifugal dust collectors-cyclones clean dust-laden air from large dust. With an increase in air speed at the entrance to the cyclone, the dust-retaining effect increases.

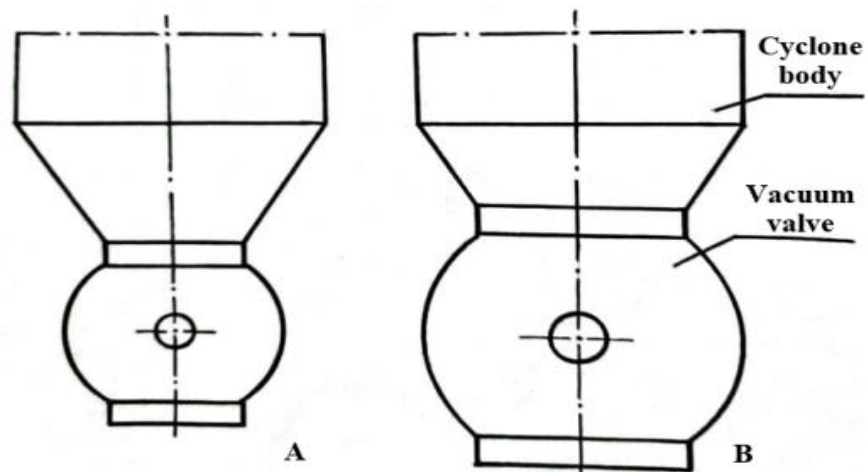
Complete elimination of suction in the cyclone is achieved by sealing the dust pipe, as well as by installing a bunker or sluice gate.

Two-stage six-cyclone installation This installation is used to purify the air leaving the pneumatic transport system of raw cotton before releasing it into the atmosphere.

Despite the provision of the necessary dust removal equipment, many problems and unresolved issues remain.

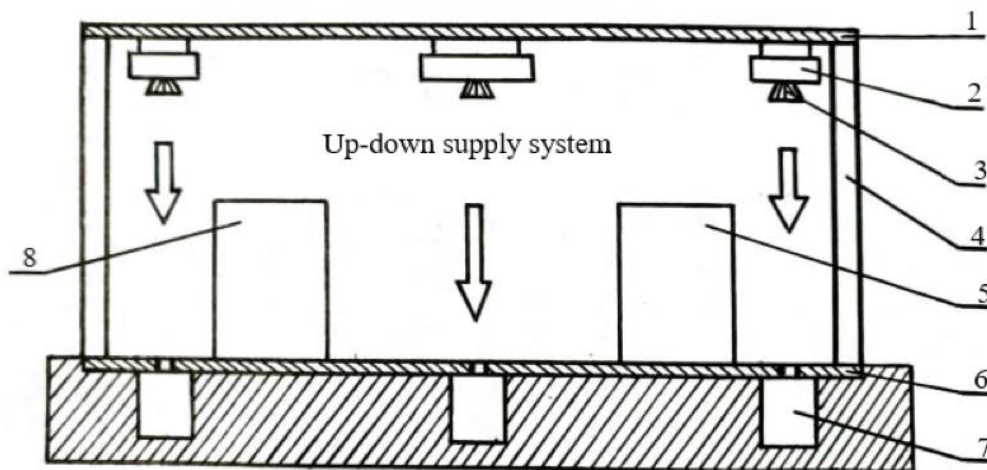
To improve dust removal at cotton ginning plants, innovative solutions are proposed for the reconstruction of the VZP-1200 cyclone and a new project for a supply and exhaust line for cotton ginning shops.

For normal operation of the VZP-1200 cyclone, we increase the dimensions of the vacuum valve 1.5 times. In this way, in practice, a high result in dust removal of workshops, as well as the territory of a cotton factory, was obtained.



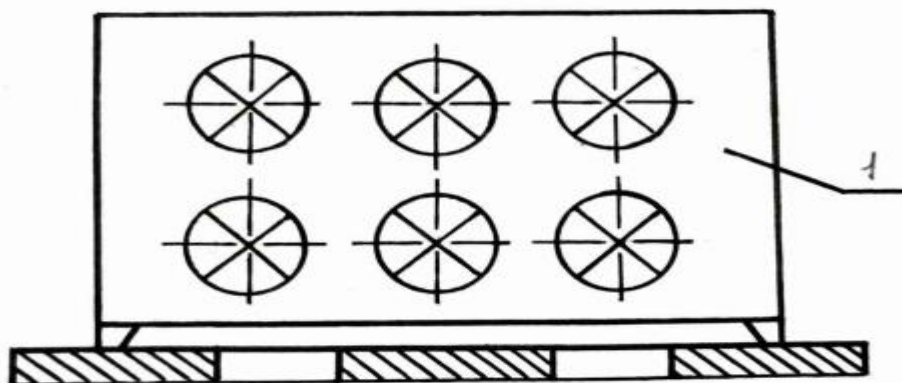
A) Existing cyclone vacuum valve. B) New enlarged cyclone vacuum valve.

Figure 1. Vacuum valve of the VZP-1200 cyclone.



1-floor, 2-supply line (box), 3-blinds, 4-workshop wall, 5-gin 4DP-130, 6-floor, 7-exhaust line (underfloor channel), 8-linter 5LP.

Figure 2. Main building of the cotton factory.



1-air conditioner, for supplying moist and clean air to the workshop through supply lines.

Figure 3. Air conditioning.

Normal operation of cyclones ensures, when processing low grade raw cotton, air purification after linter condensers up to 76 mg/m^3 with a dust retention effect of 95-97%. When cleaning the air after gin condensers, the same dust retention effect of 94-97% is achieved.

High-quality dust removal of cotton gin enterprises very positively negates the work of the new, created pneumomechanical gin for the production of high-quality seeds and cotton fiber.

Conclusions:

1. To improve dust removal at cotton ginning enterprises, it is necessary to reconstruct the VZP-1200 brand cyclone and introduce supply and exhaust lines for the cotton ginning shops, as well as for the main building.

2. After the reconstruction of cyclones and the introduction of supply and exhaust lines, the required norm ($6-10 \text{ mg/m}^3$) for dust content in the air in the production premises of the cotton gin plant is achieved.

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C O N T E N T S

PRIMARY PROCESSING OF COTTON, TEXTILE AND LIGHT INDUSTRY	
Nabidjanova N., Azimova S.	
Study of physical-mechanical properties of fabrics used for men's outer knit assortment	3
Nabidjanova N., Azimova S.	
Development of model lines of men's top knitting assortment	7
Noorullah S., Juraeva G., Inamova M., Ortiqova K., Mirzaakbarov A.	
Enhancing cotton ginning processing method for better fibre quality	12
Kamalova I., Inoyatova M., Rustamova S., Madaliyeva M.	
Creating a patterned decorative landscape using knitted shear waste on the surface of the paint product	16
Inoyatova M., Ergasheva Sh., Kamalova I., Toshpo'latov M.	
State of development of fiber products – cleaning, combing techniques and technologies	21
Vakhobova N., Nigmatova F., Kozhabergenova K.	
Study of clothing requirements for children with cerebral palsy	30
Mukhametshina E., Muradov M.	
Analysis of the improvement of pneumatic outlets in the pneumatic transport system	37
Otamirzayev A.	
Innovative solutions for dust control in cotton gining enterprises	45
Muradov M., Khuramova Kh.	
Studying the types and their composition of pollutant mixtures containing cotton seeds	50
Mukhamedjanova S.	
Modernized sewing machine bobbin cap hook thread tension regulator	53
Ruzmetov R., Kuliyeu T., Tuychiev T.	
Study of effect of drying agent component on cleaning efficiency.	57
Kuldashov G., Nabiev D.	
Optoelectronic devices for information transmission over short distances	65
Kuliev T., Abbasov I., F.Egamberdiev.	
Improving the elastic mass of fiber on the surface of the saw cylinder in fiber cleaning equipment using an additional device	73
Yusupov A., Muminov M., Iskandarova N., Shin I.	

On the influence of the wear resistance of grate bars on the technological gap between them in fiber separating machines **80**

Kuliev T., Jumabaev G., Jumaniyazov Q.

Theoretical study of fiber behavior in a new structured elongation pair **86**

GROWING, STORAGE, PROCESSING AND AGRICULTURAL PRODUCTS AND FOOD TECHNOLOGIES

Meliboyev M., Ergashev O., Qurbonov U.

Technology of freeze-drying of raw meat **96**

Davlyatov A., Khudaiberdiev A., Khamdamov A.

Physical-chemical indicators of plum oil obtained by the pressing method **102**

Tojibaev M., Khudaiberdiev A.

Development of an energy-saving technological system to improve the heat treatment stage of milk **109**

Turg'unov Sh., Mallabayev O.

Development of technology for the production of functional-oriented bread products **115**

Voqqosov Z., Khodzhiev M.

Description of proteins and poisons contained in flour produced from wheat grain produced in our republic **120**

CHEMICAL TECHNOLOGIES

Choriev I., Turaev Kh., Normurodov B.

Determination of the inhibitory efficiency of the inhibitor synthesized based on maleic anhydride by the electrochemical method **126**

Muqumova G., Turayev X., Mo'minova Sh., Kasimov Sh., Karimova N.

Spectroscopic analysis of a sorbent based on urea, formalin, and succinic acid and its complexes with ions of Cu(II), Zn(II), Ni(II) **131**

Babakhanova Kh., Abdukhalilova M.

Analysis of the composition of the fountain solution for offset printing **138**

Babakhanova Kh., Ravshanov S., Saodatov A., Saidova D.

Development of the polygraphic industry in the conditions of independence **144**

Tursunqulov J., Kutlimurotova N., Jalilov F., Rahimov S.

Determination zirconium with the solution of 1-(2-hydroxy-1-naphthoyazo)-2-naphthol-4-sulfate **151**

Allamurtova A., Tanatarov O., Sharipova A., Abdikamalova A., Kuldasheva Sh.

Synthesis of acrylamide copolymers with improved viscosity characteristics **156**

Amanova N., Turaev Kh., Alikulov R., Khaitov B., Eshdavlatov E., Makhmudova Y.	
Research physical and mechanical properties and durability of sulfur concrete	165

MECHANICS AND ENGINEERING

Abdullaev E., Zakirov V.	
Using parallel service techniques to control system load	170
Djuraev R., Kayumov U., Pardaeva Sh.	
Improving the design of water spray nozzles in cooling towers	178
Anvarjanov A., Kozokov S., Muradov R.	
Analysis of research on changing the surface of the grid in a device for cleaning cotton from fine impurities	185
Mahmudjonov M.	
Mathematical algorithm for predicting the calibration interval and metrological accuracy of gas analyzers based on international recommendations ILAC-G24:2022/OIML D 10:2022 (E)	192
Kulmuradov D.	
Evaluation of the technical condition of the engine using the analysis of the composition of gases used in internal combustion engines	197
Kiryigitov Kh., Taylakov A.	
Production wastewater treatment technologies (On the example of Ultramarine pigment production enterprise).	203
Abdullayev R.	
Improving the quality of gining on products.	208
Abdullayev R.	
Problems and solutions to the quality of the gining process in Uzbekistan.	212
Yusupov D., Avazov B.	
Influence of various mechanical impurities in transformer oils on electric and magnetic fields	216
Kharamonov M.	
Prospects for improving product quality in textile industry enterprises based on quality policy systems	223
Kharamonov M., Kosimov A.	
Problems and solutions to the quality of the gining process in Uzbekistan.	230
Mamahonov A., Abdusattarov B.	
Development of simple experimental methods for determining the coefficient of sliding and rolling friction.	237

Aliyev E., Mamahonov A.	
Development of a new rotary feeder design and based flow parameters for a seed feeder device	249
Ibrokhimova D., Akhmedov K., Mirzaumidov A.	
Theoretical analysis of the separation of fine dirt from cotton.	260
Razikov R., Abdazimov Sh., Saidov D., Amirov M.	
Causes of floods and floods and their railway and economy influence on construction.	266
Djurayev A., Nizomov T.	
Analysis of dependence on the parameters of the angles and loadings of the conveyor shaft and the drum set with a curved pile after cleaning cotton from small impurities	272
ADVANCED PEDAGOGICAL TECHNOLOGIES IN EDUCATION	
Jabbarov S.	
Introduction interdisciplinary nature to higher education institutions.	276
Tuychibaev H.	
Analysis of use of sorting algorithms in data processing.	280
Kuziev A.	
Methodology for the development of a low cargo network.	289
Niyozova O., Turayev Kh., Jumayeva Z.	
Analysis of atmospheric air of Surkhondaryo region using physico-chemical methods.	298
Isokova A.	
Analysis of methods and algorithms of creation of multimedia electronic textbooks.	307
ECONOMICAL SCIENCES	
Rashidov R., Mirjalolova M.	
Regulations of the regional development of small business.	315
Israilov R.	
Mechanism for assessment of factors affecting the development of small business subjects.	325
Yuldasheva N.	
Prospects of transition to green economy.	334
Malikova G.	
Analysis of defects and solutions in investment activity in commercial banks.	346