



ANALYSIS OF TECHNOLOGICAL PROCESS-INDUCED EXTERNAL INFLUENCES ON PUMP INSTALLATIONS AND THEIR IMPACT ON ENERGY EFFICIENCY

Ishnazarov Oybek,

Institute of Energy Problems of the Academy of Sciences of the Republic of Uzbekistan, Tashkent, Uzbekistan

Xaydarov Xumoyun,

Andijan Machine-Building Institute, Andijan, Uzbekistan

Annotation Pump installations are critical components in industrial processes, particularly in energy-intensive sectors like ethanol production. This study examines the external influences induced by technological processes, such as variations in water temperature, grain moisture, and pipeline resistance, and their impact on pump performance and energy efficiency. A mathematical model was developed to analyze these interactions, and a simulation model was validated using experimental data from an ethanol production facility.

The results show that water temperature increases of 5°C can reduce energy consumption by 7%, while higher grain moisture content, increasing by 15%, results in a 10% rise in energy consumption due to elevated flow rates and friction losses. These findings highlight the importance of real-time monitoring and adaptive control strategies, such as the use of variable frequency drives (VFDs), which were shown to optimize pump speed and yield energy savings of up to 18%.

This research underscores the need for integrating external factors into pump operation strategies to enhance energy efficiency while maintaining process reliability. Furthermore, the study validates the applicability of the simulation model for predicting pump performance under varying external conditions, with an average deviation of just 4.5% compared to experimental results.

Future research should focus on advanced optimization techniques, such as artificial intelligence-driven control algorithms, and explore the long-term effects of cavitation and other nonlinear dynamics. These approaches will further enhance the

energy efficiency of pump systems in industrial applications, promoting sustainable and cost-effective practices in Uzbekistan's growing ethanol production sector.

Key words and expressions: Pump installations, energy efficiency, ethanol production, external influences, water temperature, grain moisture, pipeline resistance, variable frequency drives, optimization, industrial sustainability

Pump installations play an essential role in industrial processes, providing the necessary hydraulic energy to transfer liquids efficiently. In industrial operations such as ethanol production, pump systems must adapt to varying operational conditions imposed by the technological process. These external conditions, such as changes in water temperature, grain moisture levels, and pipeline resistance, can profoundly impact pump performance, energy consumption, and operational costs.

In the context of ethanol production, water is a critical resource used for grain soaking, which is a preparatory step for fermentation. The efficiency of pump installations in this process is influenced by factors such as cavitation, impurities in water, and variations in demand caused by the technological workflow. Addressing these factors requires a comprehensive understanding of the interaction between external influences and pump performance.

Global studies estimate that pump systems account for approximately 20% of industrial energy consumption, highlighting the importance of optimizing their operation. Inefficiencies in pump systems not only increase energy costs but also lead to equipment wear and reduced reliability. In Uzbekistan, with its growing ethanol production industry, improving the energy efficiency of pump systems can significantly contribute to industrial sustainability and economic competitiveness.

Previous research on pump installations has largely focused on internal parameters, such as motor efficiency and hydraulic design. While these factors are crucial, external influences arising from the technological process remain underexplored. Studies conducted by Uzbek researchers, including Nosov K.B. and

Arshenevskiy N.N., have laid the groundwork for understanding pump dynamics, but a holistic approach that incorporates external factors is still needed.

This paper aims to fill this gap by analyzing the external influences specific to ethanol production, particularly during grain soaking. Through the development of a mathematical model and experimental validation, this study explores the interplay between these factors and pump performance. The findings will serve as a foundation for implementing adaptive control strategies, such as variable frequency drives, to enhance energy efficiency and operational effectiveness.

The influence of external factors on pump installations has been a focal point in numerous research studies, highlighting its critical role in industrial energy efficiency. Internationally, Vakil et al. (2020) conducted a comprehensive study on the implementation of variable frequency drives (VFDs) to regulate pump operation under fluctuating load conditions. Their findings indicated a potential energy reduction of 20-30%, especially in industries with varying water demand. Similarly, Singh and Shukla (2018) investigated the implications of cavitation on pump performance, identifying how operational adjustments could mitigate energy loss and extend equipment lifespan.

Localized studies in Uzbekistan have also contributed significantly to this field. Nosov K.B. (2015) explored how grain moisture content affects pump workload in ethanol production facilities. His work emphasized that higher moisture levels lead to increased hydraulic resistance, requiring adaptive pump control mechanisms to maintain efficiency. This aligns with the findings of Khashimov A.A. (2017), who studied cavitation effects under varying water quality conditions, providing practical recommendations for minimizing energy waste through improved water pre-treatment processes.

Pipeline resistance, a critical external influence, has been extensively analyzed by Lindorf L.S. (2014). His research demonstrated that optimizing pipeline diameters and reducing internal friction could improve energy efficiency by up to

15%. In the same vein, Sivokobylienko V.F. (2016) developed predictive mathematical models for pump performance, accounting for dynamic external variables like temperature and pressure fluctuations. These models have since been used as a benchmark for optimizing industrial pumping systems.

Arshenevskiy N.N. (2021) extended this research by evaluating the economic feasibility of integrating advanced control systems, such as artificial intelligence-driven algorithms, into pump operation. His work highlighted the potential for cost savings in small and medium-sized enterprises, particularly when coupled with renewable energy sources, as proposed by Kamalov T.S. (2019). Kamalov's study showed that solar-powered pumps equipped with adaptive controls could achieve up to 25% energy savings compared to traditional systems.

Furthermore, international research by García et al. (2019) delved into the effects of water temperature on pump efficiency, noting that higher temperatures often result in reduced viscosity, thereby impacting flow dynamics. This has significant implications for ethanol production, where temperature variations are common. Dominguez and Lopez (2020) investigated similar factors in agricultural irrigation systems, finding that tailored pump designs can mitigate the adverse effects of seasonal changes.

Collectively, these studies underscore the necessity of addressing external influences in pump system design and operation. By combining localized insights from Uzbek researchers with global best practices, this paper aims to advance the understanding of how technological processes affect energy efficiency. The methodologies and strategies discussed provide a robust framework for optimizing pump installations in energy-intensive industries like ethanol production.

Methodology

The analysis of technological process-induced external influences on pump installations and their impact on energy efficiency requires a multi-disciplinary approach combining fluid dynamics, thermodynamics, and electrical engineering

principles. This section outlines the methodology used to examine the system's response to varying operational conditions, including the technological process influences such as water temperature, grain moisture, tank filling cycles, and external hydraulic factors. A simulation model was developed to evaluate the energy efficiency and performance of the pump system under different operational scenarios. The model was validated through theoretical analysis and experimental data from an industrial ethanol production facility.

Mathematical Model of Pumping System

The primary component of the methodology is the mathematical modeling of the pumping system, where the total head H_{total} is determined as a function of external influences. The total head is calculated using the following equation:

$$H_{\text{total}} = H_{\text{static}} + H_{\text{velocity}} + H_{\text{friction}} + H_{\text{vapor}} + H_{\text{cavitation}} - H_{\text{external}} \quad (1)$$

where H_{static} represents the static head, determined by the height difference between the water level in the reservoir and the output tanks.

H_{velocity} is the velocity head, which accounts for the kinetic energy of the flow and is expressed as:

$$H_{\text{velocity}} = \frac{v^2}{2g} \quad (2)$$

where v is the flow velocity and g is the acceleration due to gravity.

H_{friction} accounts for the energy lost due to pipe friction and is computed using Darcy's equation:

$$H_{\text{friction}} = f \cdot \frac{L}{D} \cdot \frac{v^2}{2g} \quad (3)$$

where f is the Darcy friction factor, L is the length of the pipe, and D is the diameter of the pipe.

H_{vapor} corresponds to the vapor pressure head, which is necessary for avoiding cavitation. This is defined as:

$$H_{\text{vapor}} = \frac{p_{\text{vapor}}}{\rho g} \quad (4)$$

where p_{vapor} is the vapor pressure and ρ is the fluid density.

$H_{\text{cavitation}}$ represents the reduction in head due to cavitation phenomena, which can cause pump efficiency loss and damage. It is calculated by the threshold cavitation pressure p_{cav} , as:

$$H_{\text{cavitation}} = \frac{p_{\text{cav}}}{\rho g} \quad (5)$$

H_{external} represents the losses due to external influences such as grain moisture, external temperature variations, and tank filling cycles. These are modeled as an additional loss term that affects the efficiency of the pump system.

To evaluate the energy efficiency of the pump system, the hydraulic power required to drive the pump is calculated. The required power $P_{\text{hydraulic}}$ is given by

$$P_{\text{hydraulic}} = \frac{\rho Q g H_{\text{total}}}{\eta_{\text{pump}}} \quad (6)$$

where Q is the flow rate, H_{total} is the total head from (1), and η_{pump} is the efficiency of the pump. The electrical power input $P_{\text{electrical}}$ to the pump motor is determined by:

$$P_{\text{electrical}} = \frac{P_{\text{hydraulic}}}{\eta_{\text{motor}}} \quad (7)$$

where η_{motor} the efficiency of the motor driving the pump.

The energy efficiency of the system is assessed by calculating the ratio of hydraulic power to electrical power:

$$\eta_{\text{system}} = \frac{P_{\text{hydraulic}}}{P_{\text{electrical}}} \quad (8)$$

In the simulation model, the variations in external factors such as water temperature, grain moisture, and tank refill cycles are incorporated into the model by adjusting the flow rate Q and the head H over time. These factors impact the system's energy efficiency as described in the following sections.

A dynamic simulation model is developed using MATLAB/Simulink, where the pump system's behavior is tracked under varying external conditions. The simulation accounts for time-dependent changes in water temperature, grain moisture, and other external influences. A sensitivity analysis is performed by varying key input parameters such as grain moisture levels, water temperature, and pump flow rate. The sensitivity analysis helps identify the most influential parameters affecting energy consumption and system performance.

The simulation is run under multiple scenarios that reflect typical operational conditions in an industrial ethanol plant. For example, scenarios include varying grain moisture content, changes in external temperature, and different tank filling cycles. These scenarios are designed to assess the impact of external technological factors on energy efficiency. The results of the simulation are then compared to baseline performance metrics to identify potential energy savings.

To validate the simulation model, experimental data are collected from an industrial ethanol production facility. The measured data include pump power consumption, flow rates, head values, and external conditions such as temperature and grain moisture. The experimental data are compared with the simulation results to assess the accuracy of the model. A deviation analysis is conducted to quantify the error between the predicted and actual results. This helps ensure the reliability of the model in predicting energy efficiency and system performance under real-world conditions.

Finally, based on the results of the simulation and sensitivity analysis, optimization techniques are applied to improve energy efficiency. The optimization involves adjusting the operating parameters of the pumping system, such as motor speed (via variable frequency drives), to minimize energy consumption while maintaining the required flow rate and head. The optimization goal is to identify the operating conditions that maximize energy savings without compromising the technological process, such as water soaking time and grain moisture retention.

By using the developed methodology, the impact of technological process-induced external influences on the pumping system can be analyzed, and energy-efficient operating strategies can be developed and implemented in industrial applications. The model and optimization techniques provide a practical tool for improving the energy efficiency of pump installations in various industries, particularly those with variable external conditions like ethanol production.

The results of the study demonstrate the significant impact of technological process-induced external influences on the energy efficiency of pump installations. The simulation model, developed based on the methodology outlined in the previous section, was applied to a real-world ethanol production facility, where external factors such as water temperature, grain moisture, and tank filling cycles varied during operation.

The simulation results revealed that variations in external influences significantly affect the hydraulic power required by the pump. As the water temperature increased, the fluid's density decreased, leading to a reduction in the total head H_{total} , as shown in Equation (1). This reduction in head led to a lower energy requirement for the pumping system, demonstrating that higher water temperatures can lead to energy savings. Conversely, when the grain moisture content increased, the flow rate Q required for adequate soaking also increased, which in turn increased the energy consumption of the pump system due to the corresponding rise in the total head and friction losses, as outlined in Equations (3) and (4).

In one of the simulation scenarios, the water temperature increased by 5°C, leading to a 7% decrease in energy consumption compared to baseline conditions. On the other hand, an increase in grain moisture by 15% resulted in a 10% increase in energy consumption due to the increase in pump flow rates and head losses.

To validate the accuracy of the simulation model, experimental data from the ethanol production facility were used. The observed data included pump power

consumption, flow rates, and head values, alongside environmental parameters such as water temperature and grain moisture content. The experimental results showed a close agreement with the predicted values from the simulation model, with an average deviation of 4.5%, indicating the reliability of the model.

For instance, during a period of high grain moisture (above 25%), the experimental data matched the simulation predictions, showing a rise in pump power consumption of approximately 12%. In contrast, lower moisture levels (below 15%) resulted in a decrease in energy usage, as predicted by the model.

The optimization analysis, based on the simulation results, indicated that operating the pumps at lower speeds via variable frequency drives (VFD) during periods of reduced flow demand, such as during lower grain moisture or higher water temperatures, could yield substantial energy savings. The optimized strategy suggested a potential reduction in energy consumption by up to 18% during off-peak operational conditions without affecting the quality of the technological process.

The results highlight the importance of considering technological process-induced external factors when optimizing pump operation for energy efficiency. The simulation and experimental findings suggest that adaptive control strategies, taking into account changes in external factors, can lead to significant energy savings in industrial pumping systems.

The results obtained from both the simulation and experimental validation demonstrate the profound impact of technological process-induced external influences on the energy efficiency of pump installations. This section discusses the key findings and their implications for optimizing energy consumption in industrial pump systems.

The most significant external factors identified were water temperature, grain moisture, and tank filling cycles. As the water temperature increased, the fluid's density decreased, which led to a reduction in the total head (H_{total}) and, consequently, a lower energy demand. This finding supports the theory that warmer

water requires less energy for pumping, as fluid properties such as viscosity and density directly influence pump performance. The energy savings observed in the simulation (up to 7% with a 5°C rise in water temperature) underline the importance of controlling and optimizing water temperature, especially in facilities where temperature variations are substantial.

On the other hand, higher grain moisture content increased the required flow rate, leading to higher pump power consumption. This aligns with the physical principles outlined in the methodology, particularly the increase in friction losses (H_{friction}) and the total head. The observed 10% increase in energy consumption with higher grain moisture corroborates the prediction that more energy is needed to achieve the required flow in the presence of wetter grains.

The experimental validation of the simulation model revealed strong agreement between predicted and measured values, with an average deviation of just 4.5%. This confirms that the model accurately captures the dynamic behavior of the pump system under varying external conditions. The close match between simulation and experimental results enhances the reliability of the methodology and provides confidence in its application for other industrial settings with similar operational characteristics.

The optimization results indicate that adaptive control strategies, such as varying the pump speed with a variable frequency drive (VFD), can significantly enhance energy efficiency. By adjusting the pump speed to match changes in external conditions, the system can operate more efficiently, reducing energy consumption during periods of low flow demand. This approach offers considerable potential for energy savings, particularly in applications with fluctuating load demands like ethanol production, where the pump system faces varying external influences.

The results highlight the necessity of integrating external process variables into pump control strategies. As seen in this study, optimizing pump operations based on

real-time process data can reduce energy consumption without compromising the overall technological process, thus offering a practical solution for improving industrial energy efficiency.

While the study provides valuable insights into the impact of external factors on pump energy efficiency, further research is required to explore the long-term operational effects of varying external influences. Future work should focus on incorporating more complex models that account for factors like cavitation, which was only partially addressed in this study, and other non-linear dynamics in the pump system. Additionally, the potential integration of machine learning algorithms for real-time optimization could further improve energy management and system responsiveness to external process changes.

In conclusion, the study underscores the critical role of external technological influences in optimizing pump operations for energy efficiency, providing a solid foundation for further research and industrial applications.

Based on the experimental and simulation results, the following key conclusions can be drawn regarding the impact of technological process-induced external influences on pump installations and their energy efficiency:

Effect of Water Temperature on Energy Consumption: The increase in water temperature by 5°C resulted in a 7% reduction in energy consumption. This is due to the decrease in fluid density and the corresponding reduction in total head (H_{total}) required for pumping, demonstrating the potential for energy savings through temperature control.

Impact of Grain Moisture on Pump Efficiency: An increase in grain moisture content by 15% led to a 10% rise in energy consumption, as the required flow rate increased, resulting in higher friction losses and pump head. This finding highlights the importance of monitoring and adjusting operational conditions to optimize pump performance.

Validation of Simulation Model: The simulation model's predictions closely matched the experimental data, with an average deviation of just 4.5%. This validates the model as an effective tool for assessing the impact of external factors on pump energy consumption in industrial applications.

Optimization Potential with Adaptive Control: The study revealed that employing variable frequency drives (VFD) to adjust pump speeds based on external conditions could lead to up to 18% energy savings. This highlights the significant potential of adaptive control strategies to improve the energy efficiency of pump installations under varying process conditions.

In conclusion, the study emphasizes the importance of considering external influences in optimizing pump operations, with potential energy savings of up to 18% through adaptive control and environmental management.

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