

**CHARM POYABZAL SANOATI KORXONALARIDA XALQARO STANDARTLAR
VA SERTIFIKATLASHTIRISHNI TADBIQ ETISH**

**IMPLEMENTATION OF INTERNATIONAL STANDARDS AND CERTIFICATION IN
LEATHER FOOTWEAR INDUSTRY ENTERPRISES**

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Annotatsiya: Xalqaro standartlarni joriy etishning ahamiyati, ishlab chiqarish samaradorligiga ta'siri va korxonalar oldida turgan muammolar yoritiladi. O'zDSt va boshqa mos sertifikatlashtirish talablari qo'llanilishi tahlil qilinadi. Maqolada charm poyabzal sanoatida sifatni boshqarish tizimini takomillashtirish jarayonida xalqaro standartlar – ISO 9001, ISO 14001, ISO 45001, ISO 17025, Yakunda taklif va tavsiyalar ishlab chiqiladi.

Annotation: This article highlights the importance of implementing international standards, their impact on production efficiency, and the challenges faced by enterprises. It analyzes the application of O'zDSt and other relevant certification requirements. The paper examines the introduction of international standards—ISO 9001, ISO 14001, ISO 45001, ISO 17025—within the process of improving the quality management system in the leather footwear industry. Recommendations and practical suggestions are provided.

Kalit so'zlar: Ishlab chiqarish tizimlari, charm, ko'npoyabzal sanoati, ekologik xavfsizlik, avtomatlashtirilgan ishlab chiqarish tizimlari: robototexnika va avtomatlashtirish, nanotexnologiyalar. xalqaro standartlar – ISO 9001, ISO 14001, ISO 45001, ISO 17025 izohlari.

Key words: Production systems, leather, leather-footwear industry, ecological safety, automated production systems: robotics and automation, nanotechnologies, international standards – ISO 9001, ISO 14001, ISO 45001, ISO 17025 (definitions).

So'nggi yillarda O'zbekiston respublikasida charm-poyabzal sanoat tarmoqlarini rivojlantirish, ishlab chiqarilayotgan tayyor mahsulotlarning turlari va assortimentini kengaytirish, shuningdek, tarmoq korxonalarining investitsiya va eksport faoliyatini har tomonlama qo'llab-quvvatlash bo'yicha kompleks chora-tadbirlar amalga oshirilmoqda. Charm-poyabzal sanoatning jadal va barqaror rivojlanishini ta'minlash, mahalliy xom ashyoni chuqur qayta ishlash orqali birinchi navbatda tashqi bozorlarda raqobatbardosh bo'lgan yuqori qo'shilgan qiymatga ega mahsulotlar, charm va sun'iy charm poyabzal mahsulotlari ishlab chiqarishni diversifikatsiya qilish va kengaytirish – Respublikamizda dolzarb vazifalardan biri hisoblanadi. Bu vazifani bajarish uchun mahsulot sifatini oshirish zarur bo'ladi.

Charm poyabzal sanoati O'zbekistonda yengil sanoatning muhim bo'limi sifatida iqtisodiyotda barqaror o'sishni ta'minlashda katta ahamiyat kasb etadi. Ichki bozorni sifatli mahsulot bilan ta'minlash, eksport salohiyatini oshirish va xalqaro raqobatga mos mahsulotlar ishlab chiqarish uchun korxonalarda zamonaviy sifat boshqaruvi tizimlarini joriy etish zarur.

Charm poyabzal – texnologik jihatdan murakkab, ko'p bosqichli ishlab chiqarish talab qiluvchi mahsulot hisoblanadi. Sifatni nazorat qilish jarayonlari quyidagi yo'nalishlarda amalga oshiriladi:

- xom ashyo – charm sifatining barqarorligi;
- kesish, tikish, yig'ish texnologiyalarida aniqlik;
- zamonaviy uskunalari va standartlashtirilgan jarayonlar;

- tayyor mahsulotning ergonomikasi, chidamlilik testi;
- qadoqlash va logistika sifati.

Charm poyabzal sanoati mamlakat milliy iqtisodiyotida muhim tarmog' hisoblanib, terining standart assortimenti va oqsil chiqindilarini qayta ishlash mahsulotlari bilan ko'plab iste'mol tovarlari va sanoat mahsulotlarini ishlab chiqaradigan ko'plab tarmoqlarni ta'minlaydi. Tovaxomashyo zanjirining barcha bo'g'inlarining samaradorligi, ya'ni chorvachilik - kimyo - charm – poyabzal ishlab chiqarishda, charm sanoatining rivojlanish darajasiga, mahsulot assortimenti va sifatiga, uning narxiga bog'liq. Amalga oshirilayotgan islohotlar jarayonida davlatning mamlakatdagi iqtisodiy jarayonlarni tartibga solishdan o'zini olib qochish ushbu ishlab chiqarish va iqtisodiy aloqalarning parchalanishiga, ishlab chiqarishning barcha bo'g'inlarida keskin pasayishiga va aksariyat sohalarda, shu jumladan charm sanoatiga salbiy ta'sir ko'rsatishi muhimdir.

Charm poyabzal ishlab chiqarish bugungi kunda o'zining yuqori amaliy va iqtisodiy ahamiyatini saqlab qolgan holda, global sanoatning muhim tarmoqlaridan biri hisoblanadi. Ushbu soha nafaqat zamonaviy texnologiyalar va dizayn yondashuvlari bilan, balki ekologik masalalarga e'tibor qaratilishi bilan ham ajralib turadi. Charm poyabzal ishlab chiqarishning dolzarb o'rni va ahamiyati haqida quyidagi ba'zi muhim jihatlarni keltirish mumkin:

Bozor talabi va iqtisodiy ahamiyati shundaki charm poyabzalga bo'lgan ehtiyoj - charm poyabzalning mustahkam sifati va estetikligiga ko'ra hali ham iste'molchilar orasida yuqori talabga ega. Ayniqsa, ishbilarmonlik kiyimlari, maxsus ish poyabzallari va kundalik foydalanish uchun mos Charm oyoq kiyimlar doimo xaridorgir. Ishlab chiqarish hajmi – Xalqaro miqiyoda charm poyabzal sanoati jiddiy daromad keltiruvchi sohalardan biri bo'lib, ko'plab mamlakatlar uchun eksportning muhim qismi hisoblanadi. Xitoy, Hindiston, Italiya kabi davlatlar yirik ishlab chiqaruvchilar qatorida.

Zamonaviy texnologiyalarni joriy qilishda avtomatlashtirish va innovatsiyalar – charmni qayta ishlash va poyabzal tayyorlashda avtomatlashtirilgan texnologiyalar jarayonni tezlashtirib, mahsulot sifatini oshiradi. Kompyuter yordamida loyixalash (SAD) va 3D bosma texnologiyalar sohani yangi bosqichiga olib chiqmoqda. Ekologik toza ishlab chiqarish, atrof – muhitni muhofaza qilish masalalari bugungi kunda charm sanoati uchun katta ahamiyatga ega. Qayta ishlangan xomashyo va ekologik toza jarayonlarga talab oshmoqda.

Charm poyabzalning o'ziga xos xususiyatlari:

- Sifat va chidamlilik – charm poyabzal ko'rincha uzoq muddat xizmat qilishi, oyoqlar uchun qulayligi va nafas olish xususiyatiga ega material tufayli xarid qilinadi.
- Estetik jihatlar – charm mahsulotlari o'zining klassik ko'rinishi bilan zamonaviy dizaynni uyg'unlashtira oladi, bu esa moda sanoatida yuqori baholanadi.

Mahalliy va xalqaro raqobatda esa, ichki bozor uchun imkoniyatlar yani, mahalliy ishlab chiqaruvchilar o'z brendlarini rivojlantirib, sifatli charm mahsulotlari orqali imrortga muqobil bo'lishi imkoniyatiga ega. Eksport va xalqaro bozorda yuqori sifatli charm poyabzal ishlab chiqarish, xalqaro bozorga chiqishi rivojlanish uchun katta imkoniyatlar yaratadi.

Charm poyabzal ishlab chiqarishda quyidagi sifat ko'rsatkichlariga e'tibor qaratiladi:

1. Material sifatiga qo'yiladigan talablar

- Charmning tabiiyligi va turi: Tabiiy charm(yog'ochsimon, to'qilmagan yoki silliq yuzali) poyabzal uchun asosiy sifat belgilaridan biri hisoblanadi. Charmning mosligi uning mustaxkamligi, yumshoqligi va ekologik xavfsizligi bilan baholanadi.
- Namlikka chidamlilik: Charm materialining suv va namlik ta'siriga chidamligigi uzoq muddat xizmat qilishning muhim ko'rsatkichi hisoblanadi.
- Nafas olish qobiliyati: Charmning havo o'tkazuvchanligi oyoqning qulayligini ta'minlaydi va gigienik jihatdan yuqori bo'ladi.

2. Poyabzalning mustahkamligi:

- Tikiq sifati: Charm poyabzalning tikilish sifati yuqori bo'lishi kerak. Tikiqlarning mustahkam va toza bajarilishi mahsulotning chidamliligini oshiradi.
 - Yorishtirish texnologiyasi: Yorishtirilgan qismlar, ayniqsa taglik va ustki qism o'rtasidagi bog'lanish mustahkam bo'lishi lozim.
 - Taglikning sifati: Taglik materialining qattiq, egiluvchan va sirpanchiq bo'lmaganligi muhim ahamiyatga ega.
- 3. Ergonomik va qulaylik ko'rsatkichlari:**
- Foydalanuvchi qulayligi: Poyabzalning dizayni oyoq shakliga mos bo'lishi va uzoq vaqt davomida qulaylikni ta'minlashi lozim.
 - Oyoqning himoyalaniishi: Poyabzal oyoqni tashqi ta'sirlardan (urilish, sovuq, namlik) himoya qilishi zarur.
 - Oyoq deformatsiyasining oldini olish: Maxsus ortopedik talablarga javob beradigan dizayn qo'llanilishi muhim.
- 4. Estetik va tashqi ko'rinish:**
- Yuzani silliqligi: Charm yuzasida yoriqlar, nuqsonlar yoki dog'lar bo'lmasligi kerak.
 - Rang barqarorligi: Poyabzal bo'yoqlari va pardasi uzoq vaqt davomida o'z ko'rinishini yo'qotmasligi kerak.
 - Dizayn sifati: Zamonaviy va jozibador dizayn poyabzalning xaridorligini oshiradi.
- 5. Ishlab chiqarish jarayonining sifat standartlari:**
- ISO standartlarga moslik: Ishlab chiqarish jarayonida xalqaro ISO sifat standartlariga rioya qilish mahsulotni dunyo bozorida raqobatbardosh qiladi.
 - Texnologik jarayonning uzviyligi: Har bir bosqichda sifatni nazorat qilish tizimini joriy etilishi zarur.
- 6. Mahsulotning amaliy xususiyatlari:**
- Og'irligi: Charm poyabzal engil bo'lishi va foydalanuvchiga noqulaylik tug'dirmasligi kerak.
 - Iqlimga moslashuvchanlik: Mahsulot turli iqlim sharoitlarida (sovuq, issiq, namlik) samarali xizmat qilishi lozim.
 - Ishonchlilik: Poyabzalning uzoq muddat sinovdan o'tganligi va xizmat muddati uning sifatini belgilaydi.

Xalqaro standartlarning charm poyabzal sanoatiga tatbiqi

1. ISO 9001:2015 – Sifat menejmenti tizimi

ISO 9001 korxonaga ishlab chiqarish jarayonlarini standartlashtirish, mijoz talabini o'rganish, xatoliklarning oldini olish va resurslardan samarali foydalanishni ta'minlaydi.

2. ISO 14001 – Ekologik menejment tizimi

Ekologik xavfsizlikni ta'minlash, chiqindilarni kamaytirish, zararli moddalardan foydalanishni tartibga solish imkonini beradi.

3. ISO 45001 – Mehnat xavfsizligi va sog'liqni himoya qilish tizimi

Ish joyida xavfsizlikni ta'minlash, baxtsiz hodisalar sonini kamaytirish, xodimlar salomatligini himoya qiladi.

4. ISO 17025 – Laboratoriyalar akkreditatsiyasi

Poyabzal mahsulotlarini sinovdan o'tkazuvchi laboratoriyalarni xalqaro darajada tan olinishini ta'minlaydi.

3. Sertifikatlashtirish jarayonining bosqichlari

- Mahsulotni identifikatsiya qilish
- Sinovdan o'tkazish
- Texnik hujjatlarni tahlil qilish

- Ishlab chiqarish sharoitlarini tekshirish
- Sertifikat berish
- Yillik nazorat auditi

4. Xalqaro standartlarni joriy etishdagi muammolar

- malakali mutaxassislar yetishmasligi,
- sertifikatlashtirish xarajatlarining yuqoriligi,
- xom ashyo sifatining barqaror emasligi,
- laboratoriya imkoniyatlarining cheklanganligi.

5. Joriy etishning iqtisodiy samarasi

- brak mahsulotlar 18–35% gacha qisqaradi;
- eksport hajmi ortadi;
- iste'molchi ishonchi kuchayadi;
- ishlab chiqarish xarajatlari kamayadi.

6. Taklif va tavsiyalar

- ISO bo'yicha muntazam treninglar;
- sertifikat xarajatlarini subsidiyalash;
- laboratoriyalarni modernizatsiya qilish;
- raqamli sifat monitoring tizimlarini joriy etish.

Charm poyabzalning sifat ko'rsatkichlari uning material tanlashdan tortib, tayyor mahsulot sifatini nazorat qilishgacha bo'lgan barcha jarayonlarda o'z aksini topadi. Yuqori sifatli charm poyabzal uzoq muddat xizmat qiladi, foydalanuvchi uchun qulay bo'ladi va estetik talablarni qondiradi. Shu bilan birga, ekologik xavfsizlik va zamonaviy texnologiyalarni qo'llash charm poyabzal ishlab chiqarishning global standartlariga moslashtiradi. Charm poyabzal ishlab chiqarishda zamonaviy texnologiyalar sanoatni samarador, ekologik va raqobatbardosh qilishda muhim rol o'ynaydi.

Charm poyabzal ishlab chiqarishdagi zamonaviy texnologiyalar mahsulotning sifati, ishlab chiqarish jarayonining samaradorligi va ekologik talablariga javob berish imkonini oshiradi. Innovatsiyalar va avtomatlashtirilgan tizimlar yordamida ishlab chiqaruvchilar mijozlar talablarini qondiradigan yuqori sifatli, qulay va ekologik poyabzalni taqdim eta oladi. Ushbu texnologiyalar sanoatni raqobatbardosh qilish va rivojlantirishning kalitidir.

Dunyo mamlakatlari miqiyosida charm poyabzal ishlab chiqarish sanoat zonalaridan Xitoy Xalq Respublikasida katta hajmdagi charm poyabzal ishlab chiqarishi quvvati va zamonaviy texnologiyalari mavjud Xalqaro brendlar uchun ishlab chiqarish markazi sifatida tanilgan. Hindiston ham qo'lda ishlangan charm poyabzal ishlab chiqarishi bilan mashhur. Italiya Charm poyabzal ishlab chiqarish sanoatida nafaqat, Gucci, Prada va Salvatore Ferragamo kabi brendlar joylashgan. Dunyo miqiyosida mashhur charm poyabzal brendlari quyidagilar:

- Nike (AQSh): Maxsulotlarning ko'p qismi Vyetnam, Indoneziya va Xitoyda ishlab chiqariladi. Charm sport poyabzallari segmentida yetakchi.
- Adidas (Germaniya): Charm sport va casual poyabzallari bilan mashhur.
- Dr. Martens (Buyuk Britaniya): Yuqori sifatli charm botinkalari va etiklari bilan tanilgan.
- Clarks (Buyuk Britaniya): Klassik charm poyabzallarni ishlab chiqaruvchi brend.
- ECCO (Daniya): Yuqori sifatli va innovatsion charm ishlab chiqariladi.

Charm poyabzal ishlab chiqarish bo'yicha Xitoy, Hindiston, Vyetnam va Italiya kabi mamlakatlar yetakchilik qilsada, O'zbekiston ham bu sohada raqobatbardosh maxsulotlar ishlab chiqarish imkoniyatiga ega. Shuningdek O'zbekiston charm poyabzal ishlab chiqarish sanoatida Toshkent, Buxoro, Namangan, Andijon, Farg'ona va Samarqand viloyatlarida sanoat zonalarini

muvjud. Bular “O‘zcharmsanoat” uyushmasiga a‘zo korxonalar charm poyabzal ishlab chiqarishda faoldir.

Taklif va Tavsiyalar

- ISO bo‘yicha o‘quv-treninglar tashkil etish
- Sertifikatlashtirish xarajatlarini subsidiyalash
- Laboratoriya infratuzilmasini modernizatsiya qilish
- Raqamli monitoring tizimlarini joriy etish (ERP, LIMS, MES)

Charm poyabzal ishlab chiqarish bugungi kunda nafaqat iqtisodiy, balki madaniy va ekologik jihatdan ham muhim soha bo‘lib qolmoqda. Charm poyabzal sanoati Taklif va tavsiyalarni qo‘llash orqali O‘zbekistonda ham charm poyabzal mahsulotlarini rivojlantirish ichki va tashqi bozorda raqobatbardoshlikni oshirish uchun katta imkoniyatdir.

Xulosa

Charm poyabzal sanoatida sifatni boshqarish tizimini takomillashtirishda xalqaro standartlar muhim rol o‘ynaydi. Ularni keng tatbiq etish korxonalarining raqobatbardoshligini oshiradi, eksport imkoniyatlarini kengaytiradi va iqtisodiy samaradorlikni ta‘minlaydi.

In recent years, comprehensive measures have been implemented in the Republic of Uzbekistan to develop the leather-footwear industry, expand the range and assortment of finished products, and provide full support for the investment and export activities of enterprises in this sector. Ensuring the rapid and sustainable development of the leather-footwear industry, diversifying and expanding the production of high value-added products—such as natural and artificial leather footwear, primarily competitive in foreign markets—through deep processing of local raw materials has become one of the urgent tasks of our country. To achieve this, it is essential to improve product quality.

The leather footwear industry, as an important segment of the light industry in Uzbekistan, plays a significant role in ensuring stable economic growth. To supply the domestic market with high-quality products, strengthen export capacity, and manufacture products that meet international competitiveness, enterprises must introduce modern quality management systems.

Leather footwear is technologically complex and requires multi-stage production. Quality control processes are carried out in the following directions:

- raw materials – stability of leather quality;
- precision in cutting, sewing, and assembling technologies;
- modern equipment and standardized processes;
- ergonomics and durability tests of finished products;
- quality of packaging and logistics.

The leather-footwear industry is an important sector in the national economy, ensuring the supply of various consumer and industrial goods through standard leather assortments and protein-based by-products. The efficiency of all links in the commodity–raw material chain—livestock farming, chemical industry, leather processing, footwear production—is directly related to the development level of the leather industry, its product assortment, quality, and cost. During ongoing reforms, withdrawal of state regulation from economic processes may cause fragmentation in production relations, a decline in all production stages, and consequently negative effects on many industries, including the leather sector.

Leather footwear production today retains its significant practical and economic importance, and remains one of the essential branches of the global industry. This sector stands out not only with modern technological and design approaches but also with increased attention to environmental issues. The relevance and significance of leather footwear production can be described as follows:

Market demand and economic importance – Leather footwear remains highly demanded among consumers due to its durability and aesthetic appeal. Business footwear, special-work shoes, and everyday leather footwear continue to have strong demand.

Production volume – Globally, the leather footwear industry is among the sectors generating substantial revenue, forming an essential part of exports for many countries. China, India, and Italy are among the largest producers.

Introduction of modern technologies – Automation and innovative technologies in leather processing and footwear manufacturing accelerate processes and improve product quality. Computer-aided design (CAD) and 3D printing technologies are bringing the sector to a new stage.

Growing demand for eco-friendly production emphasizes environmental protection, recycled raw materials, and environmentally clean technologies.

Key characteristics of leather footwear:

1. Material quality requirements

Naturalness and type of leather: Natural leather (grain, split, or smooth surface) is a primary quality indicator. Its compatibility is evaluated based on strength, softness, and ecological safety.

Moisture resistance: Resistance to water and humidity is crucial for long service life.

Breathability: Air permeability ensures comfort and high hygiene level.

2. Footwear durability

Sewing quality: Stitching must be durable and clean.

Bonding technology: Strong connection between the outsole and upper is essential.

Outsole quality: It must be firm, flexible, and non-slip.

3. Ergonomic and comfort indicators

User comfort: The design must fit the anatomical shape of the foot.

Foot protection: The shoe must protect the foot from impact, cold, and moisture.

Orthopedic design: Prevents foot deformation.

4. Aesthetic and visual appearance

Smooth surface without cracks or defects.

Color fastness over time.

Modern and attractive design.

5. Production process quality standards

Compliance with ISO standards ensures international competitiveness.

Consistency and quality control at each production stage.

6. Practical characteristics of the product

Lightweight construction.

Adaptability to various climatic conditions.

Long-term reliability.

Application of International Standards in the Leather Footwear Industry

1. ISO 9001:2015 – Quality Management System

Ensures standardization of production processes, identification of customer needs, prevention of defects, and efficient use of resources.

2. ISO 14001 – Environmental Management System

Reduces waste, regulates the use of hazardous substances, and ensures environmental safety.

3. ISO 45001 – Occupational Health and Safety Management System

Ensures workplace safety, reduces workplace accidents, and protects employees' health.

4. ISO 17025 – Laboratory Accreditation

Ensures international recognition of footwear testing laboratories.

Stages of the Certification Process

Product identification

Testing

Technical documentation analysis

Inspection of production facilities

Certification issuance

Annual surveillance audit

Challenges in Implementing International Standards

Lack of qualified specialists

High certification costs

Inconsistent raw material quality

Limited laboratory capacity

Economic Effect of Implementation

Defective products reduced by 18–35%

Increase in export volume

Strengthening consumer trust

Reduction in production costs

Recommendations

Regular ISO training

Subsidizing certification costs

Modernization of laboratories

Introduction of digital quality monitoring systems

High-quality leather footwear reflects the entire production cycle—from raw material selection to final product quality control. Quality shoes provide long-lasting use, comfort, and aesthetic satisfaction. At the same time, environmental safety and the use of modern technologies ensure compliance with global standards.

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