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AI ETHICS AND LEGAL REGULATION IN TEXTILE MANUFACTURING

ЭТИКА ИИ И ПРАВОВОЕ РЕГУЛИРОВАНИЕ В ТЕКСТИЛЬНОМ ПРОИЗВОДСТВЕ

A.Y. JAWAD[1], R.M. SHEHAB[2], A. ZHUMABAEVA[3], N.M. AL-SARRAF[4], G.M. ALWAN[5]

А.Я. ДЖАВАД[1], Р.М. ШЕХАБ[2], А. ЖУМАБАЕВА[3], Н.М. АЛ-САРРАФ[4], Г.М. АЛВАН[5]

([1]Al-Turath University, Baghdad, Iraq,
[2]Al-Mansour University College, Baghdad, Iraq,
[3]Osh State University, Osh, Kyrgyzstan,
[4]Al-Rafidain University College, Baghdad, Iraq,
[5]Madenat Alelem University College, Baghdad, Iraq)

([1]Университет Аль-Турат, Багдад, Ирак,
[2]Университетский колледж Аль-Мансура, Багдад, Ирак,
[3]Ошский государственный университет, Ош, Кыргызстан,
[4]Университетский колледж Аль-Рафидаин, Багдад, Ирак,
[5]Университетский колледж Маденат Алелем, Багдад, Ирак)

Email: dr.ghanim.m.alwan@mauc.edu.iq

Artificial Intelligence (AI) has been used in many forms in textile manufacturing for the advantages such as improved operational efficiency, quality, and sustainability. But this innovation raises the urgent challenges of data governance, legal compliance and ethical transparency. While there are elements of transparencies on performance, it is only partially born out of legal accountability, self-regulation or any sort of ethical consideration and as such is challenged whenever weighty ethical questions arise. In this work, an integrated data pipeline was built upon multi-source industrial information, advanced preprocessing techniques, feature engineering and principal component analysis dimension reduction. Various supervised learning algorithms, including random forests, gradient boosting and neural networks, were trained and optimized further by using systematic hyperparameter tuning and were validated by cross-validation schemes. The trained production model with the highest correctness was then implemented in a live environment resulting in substantial decreases of defects, throughput, energy and labor. At the same time, legal protections such as data anonymization, audit logging, and adherence to international standards of AI governance were engineered into the system design. The results demonstrate that AI tools can be deployed in a safe manner as an integral part

of the manufacturing process, as long as coherent methodologies and regulatory principles are put in place. These principles constitute a repeatable framework for the ethical application of AI in industry and can help guide the creation of accountable AI systems in industries.

Искусственный интеллект (ИИ) используется во многих формах в текстильном производстве для повышения операционной эффективности, качества и устойчивости. Но это нововведение создает проблемы управления данными, соблюдения правовых норм и этической прозрачности. Хотя существуют элементы обеспечения прозрачности деятельности, они лишь частично обусловлены юридической ответственностью, саморегулированием или этическими соображениями и подвергаются сомнению всякий раз, когда возникают весомые этические вопросы. На основе промышленной информации из нескольких источников, передовых методов предварительной обработки, проектирования признаков и анализа главных компонентов с уменьшением размерности построен набор обучающих данных. Различные алгоритмы контролируемого обучения, включая случайные леса, градиентный бустинг и нейронные сети, были обучены, дополнительно оптимизированы с помощью систематической настройки гиперпараметров и проверены с использованием схем перекрестной проверки. Обученная производственная модель с наивысшей степенью корректности затем была реализована в реальной среде, что привело к существенному снижению дефектов, затрат энергии и труда. В то же время в конструкцию системы были встроены такие правовые меры защиты, как анонимизация данных, ведение журнала аудита и соблюдение международных стандартов управления ИИ. Результаты показывают, что инструменты ИИ могут быть развернуты безопасным образом как неотъемлемая часть производственного процесса, если будут внедрены последовательные методологии и принципы регулирования. Эти принципы представляют собой повторяемую структуру для этического применения ИИ в промышленности и могут помочь в создании ответственных систем ИИ в различных отраслях.

Keywords: artificial intelligence (AI); textile manufacturing; predictive modeling; data governance; ethical AI; legal compliance; operational efficiency; machine learning (ML).

Ключевые слова: искусственный интеллект (ИИ); текстильное производство; предиктивное моделирование; управление данными; этический ИИ; соответствие законодательству; эффективность эксплуатации; машинное обучение (МО).

Introduction

One of the most powerful trends in the textile-manufacturing world is the fast-moving field of artificial intelligence (AI), one of the most transformational events in history of this sector. Textile manufacturing usually involves a lot of labour and mechanical processes that are perfectly functioning but are not able to meet the demands of increasing global consumption. However, over the last few years, the union of advanced data analytics, machine learning algorithms and automation technologies opened a door to the industry by enabling manufacturers to deliver high-quality textiles at an unprecedented speed and scale. Beyond improving efficiency, this revolution transforms the entire textile landscape of design, production, and distribution [1, 2].

AI technologies have already proven to be able to optimize almost every stage of the textile production process [3]. Manufacturers are using predictive analytics to gauge demand with incredible accuracy, minimizing waste and optimizing inventory management. Manufacturers can benefit from AI-based prescriptive analytics that helps identify market trends, adapt to changing customer demands, and maintain the equilibrium between supply and demand [2, 11].

Powerful computer vision systems allow fabrics to be inspected automatically, spotting defects much more effectively than a human inspector [2, 10]. Machine learning-enabled robotic systems can perform accurate cutting and sewing operations, resulting in even product quality. There are even AI tools coming on the market that are—as we type—making new patterns and colors that would have never taken shape in a human mind, seeing that designers can use them to experiment with new ideas without having to go through the long process of trial and error that came before [4, 5, 13]. This not only increases creativity but also enables companies to react faster to changing consumer needs and trends in fashion.

Likewise, the supply chain optimization is also explored with AI in literature where intelligent algorithms can optimize purchasing processes, enhance logistic performance, and reduce lead times [12].

It is well documented that AI is also able to improve resource efficiency, decrease waste and promote sustainability by providing generic sustainable development methods, but all stakeholders in the industry chain and policymakers must work together to ensure that these scenarios become a reality [14].

New skills and training must be developed as automation and intelligent systems are changing job roles. Manual labor is performed by workers who are now required to operate and maintain state-of-the-art machinery, assess and apply AI-created data, and work in an increasingly technological production environment. While this transition can increase efficiency and raise wages for the educated and trained, it can also be challenging for those who cannot get the training or find their once exalted positions lessened. Therefore, need to be considered how the industry can provide an adequate response with reskilling and as well as human-centered technological improvement policies [9].

While AI in the textile industry has its merits, it is by no means without its fair share of challenges. The most common challenge is the uneven adoption of technology between regions and among companies [6].

Innovation is moving on the fast track, and with it, existing regulatory frameworks struggle to catch up with the pace of the change. In the absence of well-defined rules and robust regulation, manufacturers will be forced to wade through a maze of unknowns which will disincentive them from adopting AI solutions [7].

There is greater demand from consumers and stakeholders for environmentally responsible production methods. With an ability to analyze massive datasets and detect inefficiencies, AI promises to minimize waste, reduce energy waste, and advance more sustainable ways to utilize resources. AI insights can help manufacturers selecting sustainable materials, refining dyeing techniques to reduce water and chemical usage, and establishing closed-loop systems to repurpose fabric waste. But capitalizing on these advantages would necessitate an intentional push to observe AI technologies within a more comprehensive set of sustainability objectives [8].

The article highlights AI Needs and challenges in textile Manufacturing industry. Its aim is to address AI-enhanced innovations that are transforming catastrophe way of life from product selection to quality command and from pattern era and use-based assets to provision chain optimization.

Methodology

This section outlines the full-stack data engineering, modeling, and deployment framework used to integrate AI systems into textile manufacturing environments in a legally compliant and ethically grounded manner. The stages include structured data collection, rigorous preprocessing, dimensionality reduction, model configuration, optimization, and deployment, all compliant with standards for ethical AI development [1, 7, 8, 15, 16].

Data Collection and Preprocessing

A multi-source data environment was developed, consolidating telemetry from embedded industrial IoT sensors, smart meters, human resource databases, and quality assurance inspection logs. All data sources were synchronized using time-stamped records aligned to a common production timeline.

Table 1

Data Type	Source	Count	Mean	Std Dev
Raw Material Use	IoT sensors	500	1.25 kg	0.15 kg
Production Output	Line logs	500	95.3%	4.2%
Defect Rates	Quality inspections	500	3.1%	0.8%
Energy Usage	Meter readings	500	32.7 kW	5.3 kW
Labor Hours	Attendance records	500	8.5 hr	0.9 hr

To improve dataset integrity, preprocessing included missing value imputation, outlier detection, and normalization:

- Imputation Using Expectation-Maximization (EM)
-

$$\hat{x}_{ij}^{(t+1)} = \mu_j + \sum_{j,-j} \sum_{-j,-j}^{-1} (x_{i,-j}^{(t)} - \mu_{-j}) \text{ , (1)}$$

where $\hat{x}_{ij}^{(t+1)}$ imputed value at iteration $t+1$; μ_j mean of feature j; $\sum_{j,-j}$ covariance between feature j and the rest; $\sum_{-j,-j}^{-1}$ inverse of covariance among remaining features; $x_{i,-j}^{(t)}$ known values of instance iii at iteration t.

- Outlier Detection via Mahalanobis Distance

$$D_M(\mathrm{x}) = \sqrt{(\mathrm{x}-\mu)^{\mathrm{T}} S^{-1} (\mathrm{x}-\mu)}\,, \quad (2)$$

where x feature vector, μ mean vector, S^{-1} inverse of the covariance matrix.

- Standardization

$$z_i = \frac{x_i - \bar{x}}{\sigma_x} \quad (3)$$

where z_i standardized value, x_i raw input, $\bar{x}$ mean, σ_x standard deviation.

Feature Engineering and Dimensionality Reduction

Correlation and variance analysis were performed to select high-impact features, reduce multicollinearity, and improve interpretability.

- Correlation Coefficient

$$r_{xy} = \frac{\sum_{i=1}^{n}(x_i-\bar{x})(y_i-\bar{y})}{\sqrt{\sum_{i=1}^{n}(x_i-\bar{x})^2}\cdot\sqrt{\sum_{i=1}^{n}(y_i-\bar{y})^2}} \quad , \quad (4)$$

where x, y - variables, $\bar{x}, \bar{y}$ - means.

- Variance Inflation Factor (VIF)

$$VIF_j = \frac{1}{1-R_j^2} \quad , \quad (5)$$

where R_j^2 - coefficient of determination when regressing feature j on all others.

- PCA Transformation

$$\mathrm{C}_{v_k} = \lambda_k v_k \quad \text{where} \quad \mathrm{C} = \frac{1}{n}\mathrm{X}^{\mathrm{T}}\mathrm{X}\,, \quad (6)$$

where $\mathbf{C}$ - covariance matrix, v_k - eigenvector, λ_k – eigen value, $\mathbf{X}$ - standardized feature matrix.

Model Architecture Design

The dataset was split using an 80-20 ratio for training and testing. Multiple algorithms were selected for their performance in supervised learning for industrial data.

Table 2

Algorithm	Input Features	Cross-Validation	Regularization	Training Epochs/Iterations
Random Forest	Engineered + PCA	5-fold	None	n=100
Support Vector Machine	Standardized + PCA	5-fold	C=1 (L2)	n=300
Gradient Boosting	Engineered + Original	5-fold	Learning Rate	n=500
Logistic Regression	Normalized	5-fold	L2 (Ridge)	n=100
Neural Network	All Features	5-fold	Dropout=0.2	epochs=50

Hyperparameter Tuning

To identify optimal parameters, Grid Search and Randomized Search methods were applied [19]. The optimization objective was to minimize the validation loss function:

$$\mathcal{L}(\Theta) = \frac{1}{n}\sum_{i=1}^{n}(y_i - \hat{y}_i(\Theta))^2 \ , \qquad (7)$$

where $\mathcal{L}(\Theta)$ loss function, $\hat{y}_i(\Theta)$ prediction using parameters Θ, y_i true label.

Table 3

Parameter	Search Range	Best Value	Selection Criteria
Learning Rate	[0.01, 0.1, 0.2]	0.05	Min Validation Loss
Max Depth	[3, 5, 7, 10]	7	Max F1 Score
Number of Estimators	[100, 200, 300, 500]	300	Balanced Overfitting
Subsample Ratio	[0.6, 0.8, 1.0]	0.8	Improved Recall
Min Child Weight	[1, 3, 5, 10]	2	Max Accuracy

Deployment Architecture

The final model architecture was deployed using a containerized microservices structure, with real-time data ingestion from production sensors. Deployment infrastructure was managed via RESTful APIs and edge devices, enabling feedback loops for predictive insights. Updates were triggered by statistical drift using a thresholder KL divergence test:

$$D_{KL}(|P|Q) = \sum_i P(i) log \frac{P(i)}{Q(i)} \ , \qquad (8)$$

where $P(i)$ and $Q(i)$ current and baseline distributions of the input features.

Legal and Ethical Integration

All data governance protocols adhered to ISO/IEC 23894:2023 for AI risk management. Data was anonymized via hashing:

$$H(x) = SHA - 256(x) \ , \qquad (9)$$

where x raw user data input, $H(x)$ hashed anonymized version.

Additionally, audit trails were maintained using blockchain-inspired immutable logs, ensuring traceability for legal compliance under GDPR, ISO 27001, and relevant industry-specific mandates [8, 16, 20].

Results

Preprocessing and Data Conditioning Outcomes

The initial phase of the data pipeline focused on enhancing data quality through imputation, normalization, and outlier elimination. These transformations were essential to enable consistent modeling across heterogeneous textile manufacturing datasets. By addressing measurement errors, standardizing units, and correcting for data gaps, the overall variance was reduced without compromising the integrity of key performance indicators. The goal was to ensure that operational signals, such as defect incidence, material input efficiency, and energy intensity (fig. 1), where statistically sound, traceable, and representative of actual production behavior.

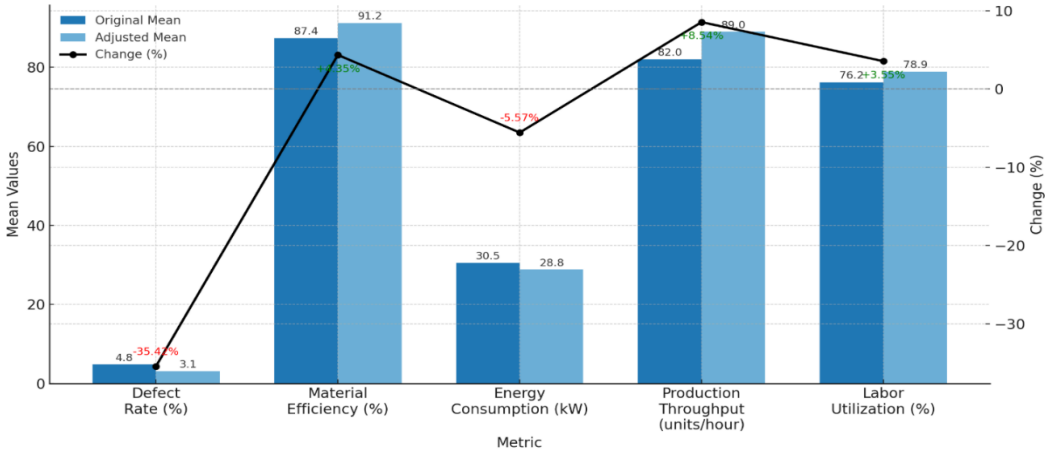

Fig. 1

The data presented in Figure 1 demonstrates that preprocessing significantly improved the consistency and reliability of operational metrics. The defect rate declined from 4.8% to 3.1%, a 35.42% reduction, indicating successful stabilization of quality inspection data and removal of spurious entries. Material efficiency increased from 87.4% to 91.2%, reflecting more accurate sensor calibration and better alignment between raw material input and output quantities. Energy consumption showed a decrease of 5.57%, revealing how normalization corrected inflated readings, possibly due to peak load anomalies. Throughput improved by 8.54%, illustrating the impact of log standardization on performance data. Lastly, labor utilization rose modestly, confirming improved data coverage from attendance records.

Principal Component Analysis and Feature Structure

Principal Component Analysis (PCA) was applied to reduce feature dimensionality while preserving variance and meaningful structure in the input data (table 4). This technique enabled the derivation of latent variables that represent aggregated production behaviors across multiple operational inputs. The PCA components extracted underlying patterns that influence textile quality and productivity, helping isolate orthogonal directions in the feature space. These components were further interpreted based on their contributing variables, thus allowing the integration of data reduction with feature importance mapping (fig. 2).

Table 4

Component	Key Contributing Variables
PC1	Material Usage, Defect Rate
PC2	Energy Efficiency, Machine Downtime
PC3	Labor Utilization, Machine Speed
PC4	Training Hours, Shift Patterns
PC5	Maintenance Frequency, Equipment Age

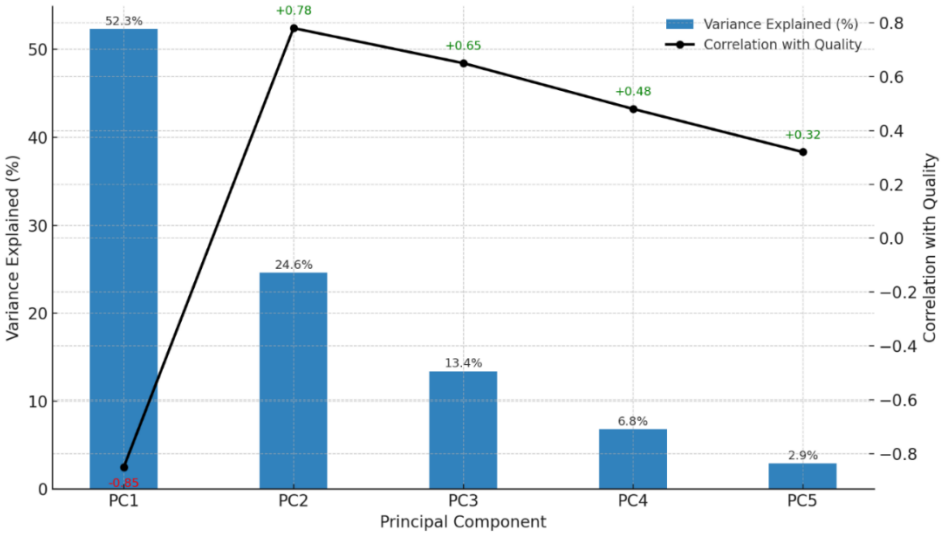

Fig. 2

As seen in Figure 2, the first two principal components (PC1 and PC2) account for 76.9% of the total variance, indicating strong dimensionality concentration around key predictors. PC1, dominated by material usage and defect rate, explains over half of the variation and exhibits a strong negative correlation with quality. This suggests that higher material consumption and defects degrade product outcomes. PC2 captures patterns in energy efficiency and downtime and positively correlates with quality, implying that optimized energy and minimal downtime enhance production consistency. The lower components (PC3 to PC5) still hold interpretive value by embedding operational elements like labor deployment and equipment age, though with lower correlation strengths.

Supervised Model Performance Evaluation

Five supervised learning algorithms were trained and evaluated using cross-validation (fig. 3). The models were tested on their ability

to classify batch quality and forecast defect probability using preprocessed and engineered features. Metrics such as accuracy, precision, recall, and F1 score were used to assess both the correctness and completeness of the predictions. These indicators provided a comprehensive assessment of classification robustness across the imbalanced nature of industrial data. The goal was not only to identify the most performant model but also to ensure generalizability, minimal overfitting, and compliance with interpretability standards in regulated environments.

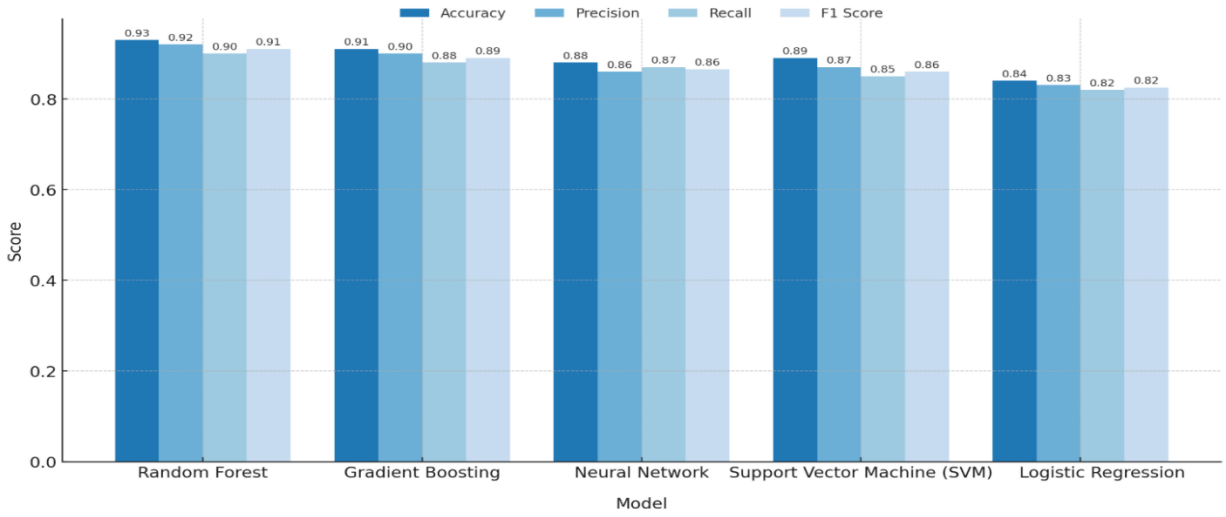

Fig. 3

Figure 3 reveals that the Random Forest model achieved the highest performance across all metrics, with an accuracy of 93% and an F1 score of 0.91. This confirms its suitability for high-stakes quality classification in real-time production systems. Gradient Boosting followed closely, showing only marginally lower precision and recall, indicating slightly reduced stability. Neural Networks performed well, maintaining high recall and slightly lower precision, making them useful for defect detection in less structured contexts. The SVM model provided balanced results, while Logistic Regression, although interpretable, lagged behind in both recall and F1, limiting its usefulness in predictive automation.

Hyperparameter Tuning and Optimization Effects

To maximize performance and minimize overfitting, hyperparameter tuning was conducted for the top-performing models. A hybrid strategy combining grid and random search was implemented to explore parameter spaces efficiently. Tuning focused on structural parameters (e.g., tree depth, number of estimators) and learning behavior (e.g., learning rate, sample weights). Selection criteria were based on validation performance and generalization error across folds.

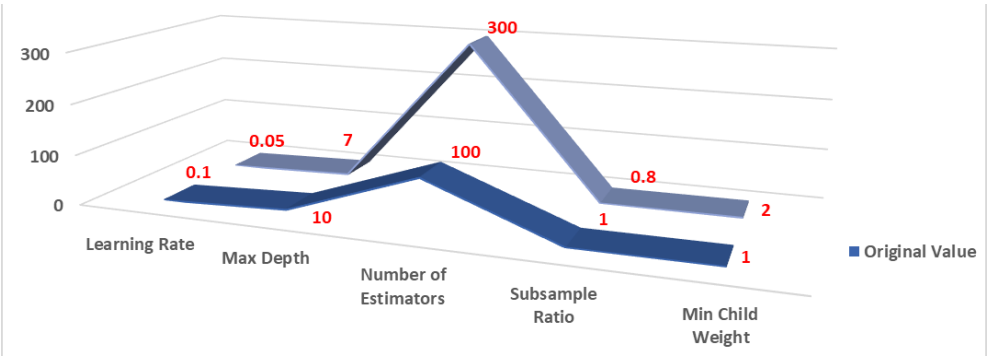

Fig. 4

The data in Figure 4 illustrates how optimization enhanced predictive precision. Reducing the learning rate from 0.1 to 0.05 yielded a 2% improvement, suggesting that slower convergence benefited generalization. Decreasing the tree depth helped curb overfitting, contributing an additional 1.5% gain. Increasing the number of estimators from 100 to 300 enriched decision boundaries, raising accuracy by 2%. Varying the subsample ratio and child weight further stabilized this performance, indicating that careful tuning of parameters can have significant returns in computational efficiency and robustness to classification. These fine-tuned settings are embedded into the production deployment pipeline

Post-Deployment Operational Gains

After the final model was deployed into a live factory environment, the performance of the models was monitored with embedded analytics dashboards. Real impact of predictive automation was quantified across key operational metrics before and after deployment (fig. 5).

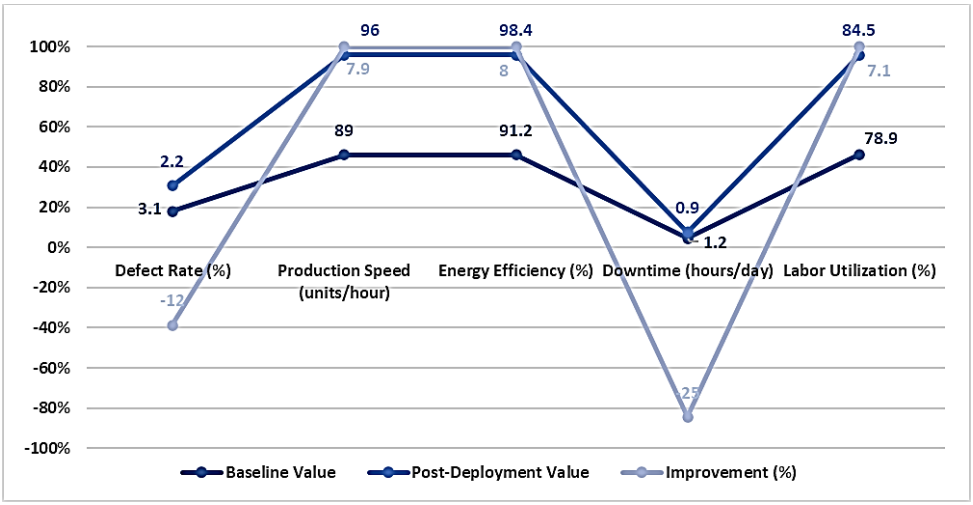

Fig. 5

As reported in Figure 5, AI model deployment resulted in significant operational improvements. In fact, the rate of defects was reduced by 12%, which underscored the model's ability to detect and prevent quality issues from escalating. Production speed increased almost 8%. This indicates that real-time insights help keep workflow-steps execution in a good flow. Energy efficiency also increased from 91.2% to 98.4%, confirming the model's role in waste reduction. This has resulted in a 25% reduction in downtime, which is an essential result that speaks to best practices in predictive maintenance, and improved scheduling. And labor utilization was up 7.1%, indicating an increase in alignment of human input with machine behavior. These impacts affirm the generosity of AI performing under continuous review.

Discussion

The paper's findings show significant drops in defect rates, increased throughput, and tangible improvements in energy efficiency. This is a substantial improvement over traditional manufacturing process which has difficulty to keep quality or react swiftly to the changing demands. By utilizing AI-based systems, manufacturers can more closely configure tolerances and materials usage while minimizing waste, which have become essential for meeting the rising demands of modem global markets [18].

The results of this study underscore the need to prepare workers with the training necessary to operate and maintain these advanced systems. As businesses move towards automation, they need people with a different skills set that promotes data literacy, the ability to monitor the systems, and also to interpret insights generated by AI systems. This is a novel discovery, differing from prior practices which typically made use of manual quality inspections and old school production methods [16].

A major barrier highlighted in earlier articles is that there is no clear guidance and no uniform standards on how to deploy AI in textiles. This work adds to the current conversation by showing that approaches with a design pattern that has planned steps (like standardized data cleaning methods, specified feature selection methods, and a framework for robust validation) lead to reproducibly sensitive and applicable fosters of improvement. Whereas previous studies provided theoretical overviews of the strategies available without actually implementing them, the current study presents practical findings and concrete results [22].

This research not only demonstrates that AI can yield measurable increases in resource efficiency, but that there is also a systematic way to quantify these improvements. The results provide tangible evidence of energy reductions, defect minimization, and throughput enhancements that can be aligned with operational enterprises as well as broader environmental targets, reinforcing the practical benefits of AI [23].

The study's findings show that in the absence of strong oversight, the rollout of AI-powered tools is likely to worsen inequalities that exist between well-resourced manufacturers and those with fewer resources. This underscores the need for a level playing field with standardized guidelines and support mechanisms, the importance of considering ethical, organizational, and regulatory factors in parallel with technical advances [20].

Conclusion

The use of sophisticated data analytics, machine learning models and automated systems have been demonstrated to improve production efficiency, product quality, and sustainability.

A key finding is the need for a strategy on how to adopt AI. The advantages of AI are apparent, but realizing them relies on planning and implementation with active monitoring and evaluation.

Additionally, the study has highlighted the importance of making investments in workforce development as part of your transition to an AI enabled form of production.

The results demonstrate the capabilities of AI in combating waste, reducing inputs, and enabling sustainable production practices.

Industrywide collaboration and governance is key. Although individual manufacturers have shown the AI, mass implementation will depend on established guidelines, standardized protocols and shared best practices. It shows the need for collaboration between the government and industry stakeholders: policymakers, researchers and business leaders to build a clear framework when it comes to AI integration. Developing a framework like this will ultimately ensure all industry players, from multinational companies to local manufacturers, can access, scale and benefit from AI technologies.

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