

The 20th Santa Fe Symposium on Jewelry Manufacturing Technology

PALLADIUM FEATURES AS A JEWELLERY METAL FOR THE FIRST TIME

Reviewed by Christopher W. Corti

CORReGOLD Technology Consultancy, Reading, U.K.; E-mail: chris@corti.force9.co.uk

The annual international Santa Fe Symposium® is the foremost source of the latest research and technical information on jewellery materials and manufacturing technology. Much of the industry's current state of knowledge on platinum jewellery alloys and manufacturing practice has been featured at this Symposium over the years (1–3). Breaking with tradition, the 2006 Symposium – the 20th Santa Fe Symposium – was held in Nashville, Tennessee, from 10th to 13th September 2006, rather than in Albuquerque, New Mexico, its spiritual home.

Introduction of Palladium

The 2006 Symposium was notable for featuring the new jewellery metal – palladium. This had been a very hot topic in the U.S., Chinese and European jewellery industries over the previous year, with many U.S. alloy suppliers launching new 950 palladium alloys on the market and the retail industry showing serious interest. However, a full technical appraisal has been awaited, and the three presentations on palladium ensured that a technical understanding of the metal was placed on a sound footing.

Palladium jewellery (Figure 1) is of interest as an alternative white jewellery metal because its low price and low density (compared with those of gold and platinum), coupled with its good white colour and tarnish resistance, make it a better low-cost alternative to 950 platinum than traditional cheaper options such as 18 and 14 carat white gold. In addition, retailers may be able to obtain more attractive margins.

The first presentation, 'The Working Properties for Jewelry Fabrication Using New Hard 950 Palladium Alloys', was by Professor Paolo Battaini (8853 SpA, Italy), who described progress to devel-

op two prototype 950 palladium alloys for wrought application. The initial work was based on palladium-copper (Pd-Cu) and palladium-gallium (Pd-Ga) alloys, with indium and other alloying additions.

The annealed hardness of the Pd-Ga alloy, at HV 170, was much higher than that of the Pd-Cu alloy at HV 70, and its melting range was substantially lower. As-cast ingots were subjected to cold rolling and annealing cycles down to thin sheet. This sheet was further subjected to a number of mechanical processing operations, and the evolution of the metallurgical structure and properties was followed. For the Pd-Ga alloy, this included roll forming with continuous tungsten inert gas (TIG) welding to form seamed tube, that was further drawn down to tube of 8.5 mm diameter (easily accomplished, but dependent on good lubrication). Other processes tested were the blanking of washers, drawing and ring rolling to form ring blanks as well as square bars being rolled and then drawn to wire of 0.7 mm diameter, using diamond nibs in the dies. Good lubrication was also important here. Tensile tests were performed on the wires. Typically, a cold-worked hardness of



Fig. 1. Working a palladium alloy ring (courtesy of Mann Design Group)

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Lei Shi



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Table of Contents Santa Fe Symposium On Jewelry Manufacturing Technology

1. Understanding the eBook Santa Fe Symposium On Jewelry Manufacturing Technology
 - The Rise of Digital Reading Santa Fe Symposium On Jewelry Manufacturing Technology
 - Advantages of eBooks Over Traditional Books
2. Identifying Santa Fe Symposium On Jewelry Manufacturing Technology
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Santa Fe Symposium On Jewelry Manufacturing Technology
 - User-Friendly Interface
4. Exploring eBook Recommendations from Santa Fe Symposium On Jewelry Manufacturing Technology
 - Personalized Recommendations
 - Santa Fe Symposium On Jewelry Manufacturing Technology User Reviews and Ratings

- Santa Fe Symposium On Jewelry Manufacturing Technology and Bestseller Lists
- 5. Accessing Santa Fe Symposium On Jewelry Manufacturing Technology Free and Paid eBooks
 - Santa Fe Symposium On Jewelry Manufacturing Technology Public Domain eBooks
 - Santa Fe Symposium On Jewelry Manufacturing Technology eBook Subscription Services
 - Santa Fe Symposium On Jewelry Manufacturing Technology Budget-Friendly Options
- 6. Navigating Santa Fe Symposium On Jewelry Manufacturing Technology eBook Formats
 - ePub, PDF, MOBI, and More
 - Santa Fe Symposium On Jewelry Manufacturing Technology Compatibility with Devices
 - Santa Fe Symposium On Jewelry Manufacturing Technology Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Santa Fe Symposium On Jewelry Manufacturing Technology
 - Highlighting and Note-Taking Santa Fe Symposium On Jewelry Manufacturing Technology
 - Interactive Elements Santa Fe Symposium On Jewelry Manufacturing Technology
- 8. Staying Engaged with Santa Fe Symposium On Jewelry Manufacturing Technology
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Santa Fe Symposium On Jewelry Manufacturing Technology
- 9. Balancing eBooks and Physical Books Santa Fe Symposium On Jewelry Manufacturing Technology
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Santa Fe Symposium On Jewelry Manufacturing Technology
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Santa Fe Symposium On Jewelry Manufacturing Technology
 - Setting Reading Goals Santa Fe Symposium On Jewelry Manufacturing Technology
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Santa Fe Symposium On Jewelry Manufacturing Technology
 - Fact-Checking eBook Content of Santa Fe Symposium On Jewelry Manufacturing Technology
 - Distinguishing Credible Sources

13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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