25 mm Black Internal Thread Tube

Rigid Straight Pipe - M10 x 1.0 Connector System

User Manual

Model 25 mm Straight Tube Series

OD 25 mm - ID approx. 23 mm - Thread depth approx. 15 mm

JIAKMJ Industrial Lighting Parts

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This manual covers the 25 mm black internal thread straight tube and the connectors that go with it: single connector, double connector, M10 x 1.0 conversion plug, end cap and hex nut.

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1. PRODUCT OVERVIEW

This is a rigid 25 mm outside-diameter black metal straight tube with an M25 x 1.0 internal thread at BOTH ends, about 15 mm deep. It is the structural pipe behind LED work lights, machine light posts, pendant rods and display fixtures, and the hollow bore doubles as a cable route.

Tubes join end to end with the DOUBLE connector to build any straight run without welding. The SINGLE connector, the M10 x 1.0 CONVERSION PLUG and the END CAP all present an M10 x 1.0 thread, so standard lamp holders, ceiling plates, brackets and machine-light bases screw straight on. Note that the tube thread and the connector thread are different sizes.

Typical users: lighting factories and assemblers, lamp repair counters, machine-tool integrators, display contractors and DIY builders.

2. TECHNICAL SPECIFICATIONS

Model	25 mm straight tube (internal thread)
Material	Iron / steel tube
Finish	Black painted, anti-corrosion
Colour	Black
Outer diameter	25 mm
Inner diameter	approx. 23 mm
Tube thread	M25 x 1.0, internal, both ends, depth approx. 15 mm
Connector thread	M10 x 1.0, male
Lengths	50 / 100 / 120 / 150 / 200 / 250 / 300 / 350 / 400 / 450 / 500 mm
Custom length	cut to order on request
Operating temperature	-20 to +80 C
Electrical rating	NONE - mechanical part, no wiring
Warranty	1 year

Dimensions are from manual measurement, for reference only. The actual product and the nameplate govern. Allow plus or minus 1 to 2 mm.

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2.1 LENGTH OPTIONS

Code	Length	Thread depth	Typical use
25-50	50 mm	approx. 15 mm	short spacer / coupler
25-100	100 mm	approx. 15 mm	small lamp stand
25-120	120 mm	approx. 15 mm	table lamp riser
25-150	150 mm	approx. 15 mm	pendant rod
25-200	200 mm	approx. 15 mm	pendant rod
25-250	250 mm	approx. 15 mm	display / rack
25-300	300 mm	approx. 15 mm	lamp post
25-350	350 mm	approx. 15 mm	lamp post
25-400	400 mm	approx. 15 mm	floor lamp riser
25-450	450 mm	approx. 15 mm	floor lamp riser
25-500	500 mm	approx. 15 mm	long post / rack

2.2 CONNECTORS AND ACCESSORIES

Part	Code	Function	Thread
Single connector	25-SC	tube end to M10 outlet	M10 x 1.0
Double connector	25-DC	joins two tubes	internal
Miter joint	25-MJ	90 degree corner run	internal
Conversion plug	25-M10	bore to M10 male	M10 x 1.0
End cap	25-CAP	closes the tube end	internal
Hex nut	25-NUT	lock nut for the thread	M10 x 1.0

Connectors, joints, plugs, end caps and nuts are SEPARATE items. They are not in the tube package unless selected on the order.

3. PACKAGE CONTENTS

- 1 x 25 mm black straight tube, selected length
- Only what you select: connector, joint, plug, end cap or nut

Screws and end caps are NOT included. Both are sold separately - select them when ordering.

4. INSTALLATION INSTRUCTIONS

Step 1 - Check the parts: confirm the tube length and that the connector you hold matches the tube thread (tube M25 x 1.0, connectors M10 x 1.0). Seat it by hand first, before applying any force.

Step 2 - Clean the threads: wipe packing dust and paint residue out of both internal threads with a dry cloth.

Step 3 - Fit the connector: screw the connector or conversion plug into the tube by hand until it seats. The thread is about 15 mm deep and must run in freely.

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Step 4 - Assemble the run: for a longer run, join tubes with double connectors and check the assembly is straight before final hand tightening.

Step 5 - Mount and check: thread the lamp holder, base or bracket onto the M10 x 1.0 end, stand or hang the assembly, then confirm it is mechanically tight and the joint does not wobble. Tighten by hand only - pliers crush the tube wall and damage the thread.

5. WIRING

NOT APPLICABLE.

The tube and its connectors are non-electrical mechanical parts. They carry no current and have no terminals. Route the lamp cable through the approx. 23 mm bore or outside the tube, and isolate the supply before any electrical work.

6. COLOUR STATUS

NOT APPLICABLE.

This part has no light source and no status indicator. The black finish is a coating, not a signal.

7. MAINTENANCE AND CARE

- Wipe with a soft dry cloth; a damp cloth is acceptable, then dry immediately.
- Do not use solvents, abrasives or wire wool - they take the black coating off.
- Keep the internal threads clean; paint chips or swarf stop full engagement.
- Re-check the joints every 6 months on vibrating machines and re-tighten by hand.
- Touch up scratches with black paint to stop rust starting on bare metal.
- Store dry. Long-term damp storage can cause rust spots inside the bore.

8. SAFETY WARNINGS

ALWAYS isolate the electrical supply before working on a lamp assembly that uses this tube.

- The tube is a mechanical support only. It is not earthed, not rated as a conductor and must never be used as an earth path.
- Do not use the tube as a structural member for loads other than a lamp of matching size.
- Do not over-tighten: excessive torque deforms the wall and destroys the thread.
- Do not cut or re-thread the tube unless you can re-paint the cut; bare steel will rust.
- Two thread sizes: tube M25 x 1.0, connectors and end cap M10 x 1.0. Never force one into the other.
- Keep small connectors and plugs away from children - choking hazard.

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9. TROUBLESHOOTING

Problem	Possible cause	Solution
Connector will not start	Thread dirty or damaged	Clean the thread; inspect the first turn
Jams after 2-3 turns	Wrong thread size (tube is M25 x 1.0)	Use the matching connector only
Joint wobbles	Connector not fully seated	Screw in by hand to the shoulder
Lamp leans	Tube bent or run not straight	Replace the tube; re-check joints
Paint flaking at the end	Pipe cut without re-painting	Use a factory-cut length
Rust inside the bore	Stored damp or cable dragged	Dry the bore; touch up; keep it capped
Tube too short	Wrong length ordered	Add a double connector and a second tube

10. WARRANTY POLICY

1 year warranty from the date of delivery. We repair or replace, at our option, any part with a manufacturing defect: wrong or damaged thread, coating defects, dimensional error against the published tolerance, or a connector that will not engage.

Not covered: damage from over-tightening or tools, cut or drilled tubes, rust from outdoor or wet storage, mismatched thread types, normal wear and any modification.

Claims require the model, the length, the order number and a photo of the defect.

11. AFTER-SALES SERVICE

Contact	Jude
Tel / WhatsApp	+86-15915305795
Email	sales01@birtechnology.com
Website	www.cnclight.com

Please quote the tube length and your order number when contacting us. Custom lengths and connector kits can be quoted on request.

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