

TEXCEL TC250 / TC450 / TC200 Crimp Chart

Document No. TC-1018

Version 1.1

11/5/2025

Note: All settings are target settings only and must be verified by user

| TEXCEL HOSE TYPE | | DASH SIZE | INCH SIZE | DN SIZE | COUPLING SERIES | Ø Crimp OD +/- 0,1mm | Ø Crimp OD +/- 0.004" | Crimp Length | Die Size | Approximate Setting | Insertion Depth |
|--|-----------|-----------|-----------|---------|-----------------|-------------------------|--------------------------|--------------|----------|---------------------|-----------------|
| HB3K, HB3KXT ISOBARIC BRAID 3000 PSI HOSE | | | | | | | | | | | |
| HB3K-4 | HB3KXT-4 | 4 | 1/4" | 6 | F2 | 16.10 | 0.634 | FULL | 16 | 0.10 | 0.925 |
| HB3K-6 | HB3KXT-6 | 6 | 3/8" | 10 | F2 | 19.50 | 0.768 | FULL | 19 | 0.50 | 1.003 |
| HB3K-8 | HB3KXT08 | 8 | 1/2" | 12 | F2 | 23.20 | 0.913 | FULL | 23 | 0.20 | 1.141 |
| HB3K-10 | | 10 | 5/8" | 16 | F2 | 28.10 | 1.106 | FULL | 27 | 1.10 | 1.259 |
| HB3K-12 | HB3KXT-12 | 12 | 3/4" | 19 | F2 | 31.60 | 1.244 | FULL | 31 | 0.60 | 1.397 |
| HB3K-16 | HB3KXT-16 | 16 | 1" | 25 | F2 | 38.90 | 1.531 | FULL | 38 | 0.90 | 1.771 |
| HB3K-10, HB3K-12, HB3K-16 (F4) | | | | | | | | | | | |
| HB3K-10 | | 10 | 5/8" | 16 | F4 | 28.90 | 1.138 | FULL | 27 | 1.90 | 1.201 |
| HB3K-12 | HB3KXT-12 | 12 | 3/4" | 19 | F4 | 33.20 | 1.307 | FULL | 31 | 2.20 | 1.397 |
| HB3K-16 | HB3KXT-16 | 16 | 1" | 25 | F4 | 40.40 | 1.591 | FULL | 38 | 2.40 | 1.889 |
| HB4K ISOBARIC BRAID 4000 PSI HOSE | | | | | | | | | | | |
| HB4K-6 | | 6 | 3/8" | 10 | F2 | 20.80 | 0.819 | FULL | 19 | 1.80 | 1.003 |
| HB4K-8 | | 8 | 1/2" | 12 | F2 | 24.30 | 0.957 | FULL | 23 | 1.30 | 1.141 |
| HB4K-10 | HB4KXT-10 | 10 | 5/8" | 16 | F2 | 28.20 | 1.110 | FULL | 27 | 1.20 | 1.259 |
| HB4K-12 | | 12 | 3/4" | 19 | F2 | 31.10 | 1.224 | FULL | 31 | 0.10 | 1.397 |
| HB4K-10, HB4K-12 (F4) | | | | | | | | | | | |
| HB4K-10 | | 10 | 5/8" | 16 | F4 | 28.90 | 1.138 | FULL | 27 | 1.90 | 1.201 |
| HB4K-12 | | 12 | 3/4" | 19 | F4 | 32.80 | 1.291 | FULL | 31 | 1.80 | 1.397 |
| HB5K, HB5KXT ISOBARIC BRAID 5000 PSI HOSE | | | | | | | | | | | |
| HB5K-4 | HB5KXT-4 | 4 | 1/4" | 6 | F2 | 16.90 | 0.665 | FULL | 16 | 0.90 | 0.925 |
| HB5K-6 | HB5KXT-6 | 6 | 3/8" | 10 | F2 | 20.90 | 0.823 | FULL | 19 | 1.90 | 1.003 |
| HB5K-8 | HB5KXT-8 | 8 | 1/2" | 12 | F2 | 24.20 | 0.953 | FULL | 23 | 1.20 | 1.141 |
| HB5K-10 | | 10 | 5/8" | 16 | F2 | 29.40 | 1.157 | FULL | 27 | 2.40 | 1.259 |
| HB5K-10 (F4) | | | | | | | | | | | |
| HB5K-10 | | 10 | 5/8" | 16 | F4 | 29.20 | 1.150 | FULL | 27 | 2.20 | 1.201 |
| HB6K ISOBARIC BRAID 6000 PSI HOSE | | | | | | | | | | | |
| HB6K-4 | | 4 | 1/4" | 6 | F2 | 16.90 | 0.665 | FULL | 16 | 0.90 | 0.925 |
| HB6K-6 | | 6 | 3/8" | 10 | F2 | 20.80 | 0.819 | FULL | 19 | 1.80 | 1.003 |
| HBR1 SAE 100R1AT BRAIDED HOSE | | | | | | | | | | | |
| HBR1-4 | | 4 | 1/4" | 6 | F2 | 16.20 | 0.638 | FULL | 16 | 0.20 | 0.925 |
| HBR1-6 | | 6 | 3/8" | 10 | F2 | 20.60 | 0.811 | FULL | 19 | 1.60 | 1.003 |
| HBR1-8 | | 8 | 1/2" | 12 | F2 | 23.90 | 0.941 | FULL | 23 | 0.90 | 1.141 |
| HBR1-10 | | 10 | 5/8" | 16 | F2 | 27.70 | 1.091 | FULL | 27 | 0.70 | 1.259 |
| HBR1-12 | | 12 | 3/4" | 19 | F2 | 31.10 | 1.224 | FULL | 31 | 0.10 | 1.397 |
| HBR1-16 | | 16 | 1" | 25 | F2 | 39.30 | 1.547 | FULL | 38 | 1.30 | 1.771 |

| | | | | | | | | | | |
|---------|----|--------|----|----|-------|-------|------|----|------|-------|
| HBR1-10 | 10 | 5/8" | 16 | F4 | 28.20 | 1.110 | FULL | 27 | 1.20 | 1.201 |
| HBR1-12 | 12 | 3/4" | 19 | F4 | 32.20 | 1.268 | FULL | 31 | 1.20 | 1.397 |
| HBR1-16 | 16 | 1" | 25 | F4 | 39.90 | 1.571 | FULL | 38 | 1.90 | 1.889 |
| HBR1-20 | 20 | 1 1/4" | 31 | F4 | 48.80 | 1.921 | FULL | 48 | 0.80 | 2.185 |
| HBR1-24 | 24 | 1 1/2" | 38 | F4 | 57.90 | 2.280 | FULL | 57 | 0.90 | 2.243 |
| HBR1-32 | 32 | 2" | 51 | F4 | 70.50 | 2.776 | FULL | 70 | 0.50 | 2.833 |

| | | | | | | | | | | |
|--------------------------------------|----|------|----|----|-------|-------|------|----|------|-------|
| HBR2 SAE 100R2AT BRAIDED HOSE | | | | | | | | | | |
| HBR2-4 | 4 | 1/4" | 6 | F2 | 17.30 | 0.681 | FULL | 16 | 1.30 | 0.925 |
| HBR2-6 | 6 | 3/8" | 10 | F2 | 21.80 | 0.858 | FULL | 19 | 2.80 | 1.003 |
| HBR2-8 | 8 | 1/2" | 12 | F2 | 25.10 | 0.988 | FULL | 23 | 2.10 | 1.141 |
| HBR2-10 | 10 | 5/8" | 16 | F2 | 28.50 | 1.122 | FULL | 27 | 1.50 | 1.259 |
| HBR2-12 | 12 | 3/4" | 19 | F2 | 32.20 | 1.268 | FULL | 31 | 1.20 | 1.397 |
| HBR2-16 | 16 | 1" | 25 | F2 | 40.30 | 1.587 | FULL | 38 | 2.30 | 1.771 |

| | | | | | | | | | | |
|---------|----|--------|----|----|-------|-------|------|----|------|-------|
| HBR2-10 | 10 | 5/8" | 16 | F4 | 29.60 | 1.165 | FULL | 27 | 2.60 | 1.201 |
| HBR2-12 | 12 | 3/4" | 19 | F4 | 33.90 | 1.335 | FULL | 31 | 2.90 | 1.397 |
| HBR2-16 | 16 | 1" | 25 | F4 | 42.10 | 1.657 | FULL | 38 | 4.10 | 1.889 |
| HBR2-20 | 20 | 1 1/4" | 31 | F4 | 51.90 | 2.043 | FULL | 48 | 3.90 | 2.185 |
| HBR2-24 | 24 | 1 1/2" | 38 | F4 | 60.10 | 2.366 | FULL | 60 | 0.10 | 2.243 |
| HBR2-32 | 32 | 2" | 51 | F4 | 72.80 | 2.866 | FULL | 70 | 2.80 | 2.833 |

| | | | | | | | | | | |
|--------------------------------------|----|------|----|----|-------|-------|------|----|------|-------|
| HHT2 SAE 100R2AT BRAIDED HOSE | | | | | | | | | | |
| HHT2-4 | 4 | 1/4" | 6 | F2 | 18.30 | 0.720 | FULL | 16 | 2.30 | 0.925 |
| HHT2-6 | 6 | 3/8" | 10 | F2 | 22.40 | 0.882 | FULL | 19 | 3.40 | 1.003 |
| HHT2-8 | 8 | 1/2" | 12 | F2 | 25.60 | 1.008 | FULL | 23 | 2.60 | 1.141 |
| HHT2-12 | 12 | 3/4" | 19 | F2 | 33.00 | 1.299 | FULL | 31 | 2.00 | 1.397 |
| HHT2-16 | 16 | 1" | 25 | F2 | 40.50 | 1.594 | FULL | 38 | 2.50 | 1.771 |

| | | | | | | | | | | |
|----------------------------------|---|------|----|----|-------|-------|------|----|------|-------|
| HBJK 10,000 PSI JACK HOSE | | | | | | | | | | |
| HBJK-04 | 4 | 1/4" | 6 | F2 | 17.00 | 0.669 | FULL | 16 | 1.00 | 0.925 |
| HBJK-06 | 6 | 3/8" | 10 | F2 | 21.20 | 0.835 | FULL | 19 | 2.20 | 1.003 |

| | | | | | | | | | | |
|---|----|--------|----|----|-------|-------|------|----|------|-------|
| HS3K ISOBARIC SPIRAL 3000 PSI HOSE | | | | | | | | | | |
| HS3K-20 | 20 | 1 1/4" | 31 | F4 | 51.80 | 2.039 | FULL | 48 | 3.80 | 2.185 |
| HS3K-24 | 24 | 1 1/2" | 38 | F4 | 60.90 | 2.398 | FULL | 60 | 0.90 | 2.243 |
| HS3K-32 | 32 | 2" | 51 | F4 | 73.30 | 2.886 | FULL | 70 | 3.30 | 2.833 |

| | | | | | | | | | | |
|---|----|--------|----|----|-------|-------|------|----|------|-------|
| HS4K ISOBARIC SPIRAL 4000 PSI HOSE | | | | | | | | | | |
| HS4K-10 | 10 | 5/8" | 16 | F4 | 30.70 | 1.209 | FULL | 27 | 3.70 | 1.201 |
| HS4K-12 | 12 | 3/4" | 19 | F4 | 34.90 | 1.374 | FULL | 34 | 0.90 | 1.397 |
| HS4K-16 | 16 | 1" | 25 | F4 | 41.60 | 1.638 | FULL | 38 | 3.60 | 1.889 |
| HS4K-20 | 20 | 1 1/4" | 31 | F4 | 51.80 | 2.039 | FULL | 48 | 3.80 | 2.185 |
| HS4K-24 | 24 | 1 1/2" | 38 | F4 | 60.90 | 2.398 | FULL | 60 | 0.90 | 2.243 |
| HS4K-32 | 32 | 2" | 51 | F4 | 72.60 | 2.858 | FULL | 70 | 2.60 | 2.833 |

| | | | | | | | | | | |
|---|---|------|----|----|-------|-------|------|----|------|-------|
| HS5K, HS5KXT ISOBARIC SPIRAL 5000 PSI HOSE | | | | | | | | | | |
| HS5K-8 | 8 | 1/2" | 12 | F4 | 26.10 | 1.028 | FULL | 23 | 3.10 | 1.122 |

| | | | | | | | | | | | |
|----------------|-----------|----|--------|----|----|-------|-------|------|----|------|-------|
| HS5K-10 | | 10 | 5/8" | 16 | F4 | 30.10 | 1.185 | FULL | 27 | 3.10 | 1.201 |
| HS5K-12 | HS5KXT-12 | 12 | 3/4" | 19 | F4 | 34.60 | 1.362 | FULL | 34 | 0.60 | 1.397 |
| HS5K-16 | HS5KXT-16 | 16 | 1" | 25 | F4 | 42.60 | 1.677 | FULL | 38 | 4.60 | 1.889 |
| HS5K-20 | | 20 | 1 1/4" | 31 | F4 | 51.80 | 2.039 | FULL | 48 | 3.80 | 2.185 |
| HS5K-24 | | 24 | 1 1/2" | 38 | F6 | 63.80 | 2.512 | FULL | 60 | 3.80 | 2.42 |
| HS5K-24-XF BIO | | 24 | 1 1/2" | 38 | F6 | 61.10 | 2.512 | FULL | 57 | 4.80 | 2.42 |
| HS5K-32 | | 32 | 2" | 51 | F6 | 76.30 | 3.004 | FULL | 74 | 2.30 | 3.325 |

| | | | | | | | | | | | |
|---|--|----|--------|----|----|-------|-------|------|----|------|-------|
| HS6K ISOBARIC SPIRAL 6000 PSI HOSE | | | | | | | | | | | |
| HS6K-8 | | 8 | 1/2" | 12 | F4 | 26.40 | 1.039 | FULL | 23 | 3.40 | 1.122 |
| HS6K-10 | | 10 | 5/8" | 16 | F4 | 30.10 | 1.185 | FULL | 27 | 3.10 | 1.201 |
| HS6K-12 | | 12 | 3/4" | 19 | F4 | 34.80 | 1.370 | FULL | 34 | 0.80 | 1.397 |
| HS6K-16 | | 16 | 1" | 25 | F4 | 42.60 | 1.677 | FULL | 38 | 4.60 | 1.889 |
| HS6K-20 XF | | 20 | 1 1/4" | 31 | F4 | 49.40 | 1.945 | FULL | 48 | 1.40 | 2.185 |
| HS6K-24 | | 24 | 1 1/2" | 38 | F6 | 63.70 | 2.508 | FULL | 60 | 3.70 | 2.42 |
| HS6K-32 | | 32 | 2" | 51 | F6 | 77.00 | 3.031 | FULL | 74 | 3.00 | 3.325 |

| | | | | | | | | | | | |
|---|--|----|--------|----|----|-------|-------|------|----|------|-------|
| HBR4 SAE 100R4 SUCTION RETURN HOSE | | | | | | | | | | | |
| HBR4-12 | | 12 | 3/4" | 19 | FS | 30.78 | 1.212 | FULL | 27 | 3.78 | 0.996 |
| | | 12 | 3/4" | 19 | F2 | 33.60 | 1.323 | FULL | 31 | 2.60 | 1.397 |
| HBR4-16 | | 16 | 1" | 25 | FS | 38.86 | 1.530 | FULL | 38 | 0.86 | 1.137 |
| | | 16 | 1" | 25 | F2 | 41.40 | 1.630 | FULL | 38 | 3.40 | 1.771 |
| HBR4-20 | | 20 | 1 1/4" | 31 | FS | 44.86 | 1.766 | FULL | 38 | 6.86 | 1.52 |
| | | 20 | 1 1/4" | 31 | F4 | 51.90 | 2.043 | FULL | 48 | 3.90 | 2.185 |
| HBR4-24 | | 24 | 1 1/2" | 38 | FS | 52.70 | 2.075 | FULL | 48 | 4.70 | 1.617 |
| | | 24 | 1 1/2" | 38 | F4 | 61.40 | 2.417 | FULL | 60 | 1.40 | 2.243 |
| HBR4-32 | | 32 | 2" | 51 | FS | 63.91 | 2.516 | FULL | 60 | 3.91 | 2.025 |
| | | 32 | 2" | 51 | F4 | 71.90 | 2.831 | FULL | 70 | 1.90 | 2.833 |

| | | | | | | | | | | | |
|--|-----------|----|----------|----|----|-------|-------|--------|------|------|-------|
| HBR5, HBHTR5 SAE 100R5 BRAIDED HOSE | | | | | | | | | | | |
| HBR5-4 | HBHTR5-4 | 4 | 3/16" | 5 | F5 | 15.50 | 0.610 | FULL | 14 | 1.50 | 0.866 |
| HBR5-5 | HBHTR5-5 | 5 | 1/4" | 6 | F5 | 18.10 | 0.716 | FULL | 16 | 2.10 | 0.925 |
| HBR5-6 | HBHTR5-6 | 6 | 5/16" | 8 | F5 | 20.40 | 0.803 | FULL | 19 | 1.40 | 0.925 |
| HBR5-8 | HBHTR5-8 | 8 | 13/32" | 10 | F5 | 21.80 | 0.858 | FULL | 19 | 2.80 | 1.004 |
| HBR5-10 | HBHTR5-10 | 10 | 1/2" | 12 | F5 | 26.50 | 1.043 | FULL | 23 | 3.50 | 1.142 |
| HBR5-12 | HBHTR5-12 | 12 | 5/8" | 16 | F5 | 30.60 | 1.205 | FULL | 27 | 3.60 | 1.201 |
| HBR5-16 | HBHTR5-16 | 16 | 7/8" | 22 | F5 | 35.30 | 1.390 | FULL | 34 | 1.30 | 1.791 |
| HBR5-20 | HBHTR5-20 | 20 | 1 1/8" | 28 | F5 | 43.30 | 1.705 | FULL | 38 | 5.40 | 1.791 |
| HBR5-24 | HBHTR5-24 | 24 | 1 3/8" | 35 | F5 | 46.60 | 1.835 | 1.780* | 43** | 3.70 | 1.969 |
| HBR5-32 | HBHTR5-32 | 32 | 1 13/16" | 46 | F5 | 59.60 | 2.346 | FULL | 57 | 2.60 | 2.244 |

| | | | | | | | | | | | |
|---|--------|----|------|----|----|-------|-------|--------|------|------|-------|
| TR7, TTR7, TNCR7, TTNCR7 SAE 100R7 THERMOPLASTIC | | | | | | | | | | | |
| TR7-2 | | 2 | 1/8" | 4 | FT | 10.60 | 0.417 | 0.450* | 10** | 0.60 | 0.531 |
| TR7-4 | TTR7-4 | 4 | 1/4" | 6 | FT | 14.60 | 0.575 | FULL | 14 | 0.60 | 0.906 |
| TR7-6 | TTR7-6 | 6 | 3/8" | 10 | FT | 18.80 | 0.740 | FULL | 16 | 2.80 | 1.004 |
| TR7-8 | TTR7-8 | 8 | 1/2" | 12 | FT | 24.20 | 0.953 | FULL | 23 | 1.20 | 1.142 |
| TR7-12 | | 12 | 3/4" | 19 | FT | 30.70 | 1.209 | 1.180* | 27 | 3.70 | 1.398 |

| | | | | | | | | | | | |
|---|--|--|--|--|--|--|--|--|--|--|--|
| TR8, TTR8, TNCR8 SAE 100R8 THERMOPLASTIC | | | | | | | | | | | |
|---|--|--|--|--|--|--|--|--|--|--|--|

| | | | | | | | | | | | | | |
|-------|--------|---------|--|---|------|----|----|-------|-------|------|----|------|-------|
| TR8-4 | TTR8-4 | TNCR8-4 | | 4 | 1/4" | 6 | FT | 14.20 | 0.559 | FULL | 14 | 0.20 | 0.906 |
| TR8-6 | TTR8-6 | TNCR8-6 | | 6 | 3/8" | 10 | FT | 18.50 | 0.728 | FULL | 16 | 2.50 | 1.004 |
| TR8-8 | TTR8-8 | TNCR8-8 | | 8 | 1/2" | 12 | FT | 23.50 | 0.925 | FULL | 23 | 0.50 | 1.142 |

| BR14 SAE 100R14 TEFLON HOSE | | | | | | | | | | | | | |
|-----------------------------|--|--|--|----|------|----|----|-------|-------|--------|------|------|-------|
| BR14-4 | | | | 4 | 1/4" | 6 | FT | 12.60 | 0.496 | 0.748* | 12** | 0.60 | 0.906 |
| BR14-6 | | | | 6 | 3/8" | 10 | FT | 16.40 | 0.646 | 0.866* | 16 | 0.40 | 1.004 |
| BR14-8 | | | | 8 | 1/2" | 12 | FT | 20.40 | 0.803 | 1.024* | 19 | 1.40 | 1.142 |
| BR14-10 | | | | 10 | 5/8" | 16 | FT | 25.50 | 1.004 | 1.024* | 23 | 2.50 | 1.26 |
| BR14-12 | | | | 12 | 3/4" | 19 | FT | 28.00 | 1.102 | 1.181* | 27 | 1.00 | 1.398 |
| BR14-16 | | | | 16 | 1" | 25 | FT | 35.40 | 1.394 | 1.457* | 34 | 1.40 | 1.772 |

| TEX-PUSH-ON 300 HOSE | | | | | | | | | | | | | |
|----------------------|--|--|--|----|------|----|----|-------|-------|------|----|------|-------|
| PUSH-4 | | | | 4 | 1/4" | 6 | FT | 15.80 | 0.622 | FULL | 14 | 1.80 | 0.906 |
| PUSH-6 | | | | 6 | 3/8" | 10 | FT | 19.30 | 0.760 | FULL | 19 | 0.30 | 1.004 |
| PUSH-8 | | | | 8 | 1/2" | 12 | FT | 23.10 | 0.909 | FULL | 23 | 0.10 | 1.142 |
| PUSH-12 | | | | 12 | 3/4" | 19 | FT | 31.20 | 1.228 | FULL | 31 | 0.20 | 1.398 |

| TEX-GS GENERAL SERVICE 250/300 AIR HOSE | | | | | | | | | | | | | |
|---|--|--|--|---|------|----|----|-------|-------|------|----|------|-------|
| TEX-GS-4 | | | | 4 | 1/4" | 6 | FT | 16.00 | 0.630 | FULL | 16 | 0.00 | 0.906 |
| TEX-GS-6 | | | | 6 | 3/8" | 10 | FT | 19.70 | 0.776 | FULL | 19 | 0.70 | 1.004 |
| TEX-GS-8 | | | | 8 | 1/2" | 12 | FT | 25.00 | 0.984 | FULL | 23 | 2.00 | 1.142 |

| TEX-MP MULTIPURPOSE 300 AIR HOSE | | | | | | | | | | | | | |
|----------------------------------|--|--|--|---|------|----|----|-------|-------|------|----|------|-------|
| TEX-MP-4 | | | | 4 | 1/4" | 6 | FT | 15.90 | 0.626 | FULL | 14 | 1.90 | 0.906 |
| TEX-MP-6 | | | | 6 | 3/8" | 10 | FT | 19.70 | 0.776 | FULL | 19 | 0.70 | 1.004 |
| TEX-MP-8 | | | | 8 | 1/2" | 12 | FT | 25.00 | 0.984 | FULL | 23 | 2.00 | 1.142 |

* Crimp Length Measured From Tail Of Ferrule = Bubble Crimp

**Optional Die Required

