

JUKI



MO-6800S Series

High-speed, Overlock / Safety Stitch Machine

The advanced overlock / safety stitch machine is easier to use and promises superior cost effectiveness.



MO-6816S

MO-6800S SERIES

High-speed, Overlock / Safety Stitch Machine

SPECIFICATIONS

| Model name | MO-6804S | MO-6814S | MO-6816S | MO-6843S |
|------------------------------------|---|-------------------|------------------|---------------------------|
| Stitch type | 1-needle overlock | 2-needle overlock | Safety stitching | 3-needle safety stitching |
| Stitch style in the U.S.A. | 504 | 514 | 516 | — |
| Max. sewing speed | 7,000sti/min | | | |
| Stitch length | 0.6 ~ 3.8 (4.5) mm | | | |
| Needle gauge (mm) | — | 2.0 | 3.0, 5.0 | 3.0+2.0, 5.0+2.0 |
| Overedging width (mm) | 1.5, 4.0 | 2.0, 3.0, 4.0 | 4.0, 5.0, 6.0 | 3.0 |
| Differential feed ratio | For gathering 1:2 (Max. 1:4), For stretching 1:0.7 (Max. 1:0.6) | | | |
| Needle bar stroke | 24.5mm(60H:27.0mm) | | | |
| Inclination angle of the needle | 20° | | | |
| Needle bar bushing | Lower bushing method | | | |
| Needle | DCx27 (excluding some subclass model) | | | |
| Max. lift of the presser foot | 7mm (excluding some subclass model) | | | |
| Max. presser foot pressure | 63.7N (6.5kgf) | | | |
| Stitch adjusting method | By push-button | | | |
| Differential-feed adjusting method | By lever (with micro-adjustment) | | | |
| Weight of the machine head | 27kg | | | |
| Lubrication | Automatic | | | |
| Lubricating oil | JUKI Machine Oil 18 (equivalent to ISO VG18) | | | |
| Needle cooler | Provided as standard | | | |
| Needle thread heat remover | Provided as standard | | | |
| Micro-lifter | Option | | | |

*"sti/min" stands for "Stitches per Minute."

WHEN YOU PLACE ORDERS

Please note when placing orders, that the model name should be written as follows:

| Stitch type | U.S.A | Code | Type | Code | Device and attachment | Code |
|------------------------------|-------|------|----------|------|--|----------|
| 1-needle overlock | 504 | 04 | Standard | S | Tape attaching presser foot (for sewing sharp curves) / Tape guide | G44/Q143 |
| 2-needle overlock | 514 | 14 | | | Clean finish top and bottom | N075 |
| 2-needle safety stitch | 516 | 16 | | | | |
| 3-needle safety stitch | | 43 | | | | |
| 2-needle double chain stitch | | 45 | | | | |

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| Needle gauge (mm) | Overedging width (mm) | Feed dog | Code | Material | Application | Special machine | Code |
|-------------------|-----------------------|----------|------|------------------------------|---|-----------------|------------------------|
| — | 1.5 | 2-row | 0A4 | Extra light- to light-weight | Light-weight materials | Rolled hemming | Standard 150 |
| — | 4.0 | 2-row | 0E4 | Light- to medium-weight | Specific to knits | Tape attaching | Standard 24H |
| 2.0 | 2.0 | 3-row | BB6 | | For general fabrics | Standard | Standard 30H |
| 2.0 | 3.0 | 3-row | BD6 | | | Standard | Anti-marerial-slip 30P |
| 2.0 | 4.0 | 3-row | BE6 | | | Tape attaching | Standard 34H |
| 3.0 | 4.0 | 2-row | DE4 | Medium- to heavy-weight | Rolling-in tape | Standard 360 | |
| 3.0 | 4.0 | 3-row | DE6 | | Standard | Standard 40H | |
| 5.0 | 5.0 | 3-row | FF6 | | Tape attaching | Standard 44H | |
| 5.0 | 6.0 | 3-row | FH6 | heavy-weight | Medium- to heavy-weight materials such as denim | Standard | Standard 50H |
| 5.0+2.0 | 3.0 | 3-row | 1D6 | | Standard | Standard 60H | |
| 3.0+2.0 | 3.0 | 3-row | 2D6 | | | | |

JUKI ECO PRODUCTS The MO-6800S is an eco-friendly product which complies with JUKI ECO PRODUCTS standards for protecting the environment.

● The sewing machine complies with the "Juki Group Green Procurement Guidelines" on the use of hazardous substances, which is stricter than other restrictions, such as those of the RoHS Directive.

For details of JUKI ECO PRODUCTS, refer to: http://www.juki.co.jp/eco_e/index.html

*The RoHS Directive is an EU Directive limiting the use of 6 hazardous substances (lead, hexavalent chromium, mercury, cadmium, PBB and PBDE) in electrical and electronic equipment.
The Juki Green Procurement Guideline is the voluntarily established criteria to eliminate not only the aforementioned six substances, but also other ones which also adversely affect the environment.



Registered Organization : JUKI CORPORATION Head Office
The Scope of the Registration : The activities of research, development, design, sales, distribution, and maintenance services of industrial sewing machines, household sewing machines and industrial robots, etc., including sales and maintenance services of data entry systems.

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JUKI CORPORATION
SEWING MACHINERY & SYSTEMS BUSINESS UNIT

- * Specifications and appearance are subject to change without prior notice for improvement.
- * Read the instruction manual before putting the machine into service to ensure safety.
- * This catalogue prints with environment-friendly soyink on recycle paper.
- * Paper from responsible sources FSC™ C001712

MO-6800S SERIES

This advanced overlock / safety stitch machine is easier to use and promises superior cost effectiveness.

The MO-6800S Series responds to various kinds of sewing materials and processes, producing delicate and beautiful soft-to-the-touch seams while further reducing operating noise as well as increasing durability. This advanced overlock / safety stitch machine is easier to use and promises superior cost-effectiveness.

The machine achieves beautifully finished seams of improved quality even when run at a high speed.

The machine is widely applicable to the sewing of light- to heavy-weight materials. Since the machine is provided with a needle thread take-up mechanism and a looper thread take-up lever, it ensures high-quality, well-tensed and soft seams with a beautiful texture which flexibly correspond to the elasticity of the materials even when run at speeds as high as 7,000 sti/min. In addition, the machine has a wider and brighter needle entry and provides improved responsiveness to the materials, thereby helping the operator use the machine more easily. The optimally-balanced design of the machine reduces both operating noise and vibration, contributing to more comfortable sewing work.



MO-6814S

The machine is provided with functions which contribute to easier operation.

The differential-feed micro-adjustment mechanism, external increasing of the differential feed ratio and the main feed dog height can all be adjustable on the front face of the sewing machine with a screwdriver. The machine is provided as standard with functions which enable easy and best-suited adjustments according to the material to be used.



Differential-feed micro-adjustment mechanism



For runstitch / MO-6816S-FF6-30H

DEVICES AND ATTACHMENTS

| Model | Part No. | Description |
|-------|----------|-------------|
|-------|----------|-------------|

Chain-off thread trimming device

| | | |
|------|----------|--|
| T053 | 70000081 | Pneumatic flat cutter |
| T054 | 70000082 | Pneumatic side cutter (for overlock machine) |

Pneumatic chain-off thread suction device

| Model | Part No. | Pneumatic chain-off thread + cloth chips clutch motor | Air type auto-lifter | Clutch motor | Servo motor |
|-------|----------|---|----------------------|--------------|-------------|
| MC906 | 70000085 | ● | | ● | |
| MC909 | 70000104 | ● | | | ● |
| MC910 | 70000106 | ● | ● | ● | |
| MC911 | 70000107 | ● | ● | | ● |

[Reference]

Combination table of "chain-off thread suction device" and "auto-lifter" which correspond to "chain-off thread trimming device".

| Chain-off thread trimming device | Chain-off thread suction device | Auto-lifter |
|----------------------------------|---------------------------------|-----------------------------------|
| T053 or T054 | MC906 | Clutch motor |
| | MC909 | servo motor |
| | MC910 | Air type auto-lifter clutch motor |
| | MC911 | Air type auto-lifter servo motor |

| Model | Part No. | Description | Feature |
|-------|----------|-------------|---------|
|-------|----------|-------------|---------|

Gathering device

| | | | |
|------|----------|--|---|
| S206 | 70000089 | Swing-type gathering device (interlocked with pedal / for overlock machine)(with BE6 gauge) | The attachment opens with the presser foot pedal. This facilitates material setting on the machine. |
| S207 | 70000090 | Swing-type gathering device (interlocked with pedal / for safety stitch machine)(with DF6 gauge) | |
| S208 | 70000091 | Swing-type gathering device (interlocked with pedal / for safety stitch machine)(with FF6 gauge) | |

Guide, tape guide

| | | | |
|------|----------|--|--|
| H253 | 40159861 | Cloth edge guide ruler (for overlock machine) | A swing type edge guide. |
| H254 | 40159862 | Cloth edge guide ruler (for safety stitch machine) | |
| Q143 | 40159863 | Tape guide | This attachment is used attached on the machine head (face plate). It is used for tapes with the width of 7mm or less. |

SUBCLASS MACHINE LIST

| Seams | Model No. | Materials | Number of needles | Number of threads | Needle gauge (mm) | Overredging width | Number of feed dog rows | Stitch length (mm) | Bottom differential feed ratio | Presser lifting amount (mm) | Needle system | Max sewing speed (sti/min) | Remarks |
|-------|-----------|-----------|-------------------|-------------------|-------------------|-------------------|-------------------------|--------------------|--------------------------------|-----------------------------|---------------|----------------------------|---------|
|-------|-----------|-----------|-------------------|-------------------|-------------------|-------------------|-------------------------|--------------------|--------------------------------|-----------------------------|---------------|----------------------------|---------|

● [1-needle overlock]

For runstitching in general fabric

| | | | | | | | | | | | | | |
|--|------------------|-----|---|---|---|-----|---|-----|-----------|-----|-----------|-------|--|
| | MO-6804S-0E4-30H | L~M | 1 | 3 | — | 4.0 | 2 | 3.8 | 1:0.7~1:2 | 6.0 | DCx27 #11 | 7,000 | |
|--|------------------|-----|---|---|---|-----|---|-----|-----------|-----|-----------|-------|--|

For rolled hemming (folded downward)

| | | | | | | | | | | | | | |
|--|------------------|------|---|---|---|-----|---|-----|-----------|-----|---------|-------|--|
| | MO-6804S-0A4-150 | EL~L | 1 | 3 | — | 1.5 | 2 | 3.8 | 1:0.7~1:2 | 6.0 | DCx1 #8 | 7,000 | |
|--|------------------|------|---|---|---|-----|---|-----|-----------|-----|---------|-------|--|

● [2-needle overlock]

For runstitching in general fabric

| | | | | | | | | | | | | | | |
|--|------------------|-----|---|---|-----|-----|---|-----|-----------|-----|-----------|-------|--|--------------------|
| | MO-6814S-BD6-30H | L~M | 2 | 4 | 2.0 | 3.0 | 3 | 3.8 | 1:0.7~1:2 | 5.5 | DCx27 #11 | 7,000 | | |
| | MO-6814S-BE6-40H | M~H | 2 | 4 | 2.0 | 4.0 | 3 | 3.8 | 1:0.7~1:2 | 5.5 | DCx27 #11 | 6,500 | | |
| | MO-6814S-BB6-30P | L~M | 2 | 4 | 2.0 | 2.0 | 3 | 3.8 | 1:0.7~1:2 | 5.0 | DCx27 #11 | 7,000 | | Anti-material-slip |
| | MO-6814S-BE6-30P | | 2 | 4 | 2.0 | 4.0 | 3 | 3.8 | 1:0.7~1:2 | 5.0 | DCx27 #11 | 7,000 | | |

For tape attaching G44: Tape attaching presser foot Q143: Tape guide

| | | | | | | | | | | | | | |
|--|---------------------------|-----|---|---|-----|-----|---|-----|-----------|-----|-----------|-------|--|
| | MO-6814S-BD6-24H/G44/Q143 | L~M | 2 | 4 | 2.0 | 3.0 | 3 | 3.8 | 1:0.7~1:2 | 5.5 | DCx27 #9 | 7,000 | |
| | MO-6814S-BE6-24H/G44/Q143 | | 2 | 4 | 2.0 | 4.0 | 3 | 3.8 | 1:0.7~1:2 | 5.5 | DCx27 #9 | 7,000 | |
| | MO-6814S-BD6-34H/G44/Q143 | | 2 | 4 | 2.0 | 3.0 | 3 | 3.8 | 1:0.7~1:2 | 5.5 | DCx27 #11 | 7,000 | |
| | MO-6814S-BE6-34H/G44/Q143 | | 2 | 4 | 2.0 | 4.0 | 3 | 3.8 | 1:0.7~1:2 | 5.5 | DCx27 #11 | 7,000 | |
| | MO-6814S-BE6-44H/G44/Q143 | M~H | 2 | 4 | 2.0 | 4.0 | 3 | 3.8 | 1:0.7~1:2 | 7.0 | DCx27 #14 | 6,500 | |

● [Safety stitching]

For runstitching in general fabric

| | | | | | | | | | | | | | |
|------------------|------------------|-----|---|-----|-----|-----|-----|-----------|-------------|-----------|-----------|--------------------|--|
| | MO-6816S-DE6-30H | L~M | 2 | 5 | 3.0 | 4.0 | 3 | 3.8 | 1:0.7~1:2 | 5.5 | DCx27 #11 | 7,000 | |
| | MO-6816S-FF6-30H | | 2 | 5 | 5.0 | 5.0 | 3 | 3.8 | 1:0.7~1:2 | 5.5 | DCx27 #11 | 7,000 | |
| | MO-6816S-FF6-50H | M~H | 2 | 5 | 5.0 | 5.0 | 3 | 3.8 | 1:0.7~1:2 | 7.0 | DCx27 #16 | 6,500 | |
| | MO-6816S-FH6-50H | | 2 | 5 | 5.0 | 6.0 | 3 | 3.8 | 1:0.7~1:2 | 7.0 | DCx27 #16 | 6,500 | |
| | MO-6816S-FF6-60H | H | 2 | 5 | 5.0 | 5.0 | 3 | 4.5 | 1:0.9~1:1.7 | 7.0 | DCx27 #21 | 6,000 | |
| | MO-6816S-FH6-60H | | 2 | 5 | 5.0 | 6.0 | 3 | 4.5 | 1:0.9~1:1.7 | 7.0 | DCx27 #21 | 6,000 | |
| MO-6816S-DE4-30P | L~M | 2 | 5 | 3.0 | 4.0 | 2 | 3.8 | 1:0.7~1:2 | 5.0 | DCx27 #11 | 7,000 | Anti-material-slip | |

For rolling-in tape N075: Clean finish top and bottom

| | | | | | | | | | | | | | |
|--|-----------------------|-----|---|---|-----|-----|---|-----|-----------|-----|-----------|-------|---|
| | MO-6845S-FF6-360/N075 | M~H | 2 | 4 | 5.0 | 5.0 | 3 | 3.8 | 1:0.7~1:2 | 5.0 | DCx27 #14 | 7,000 | 2-needle type for double-chainstitch on pocket bags |
|--|-----------------------|-----|---|---|-----|-----|---|-----|-----------|-----|-----------|-------|---|

● [3-needle safety stitching]

| | | | | | | | | | | | | | |
|--|------------------|-----|---|---|---------|-----|---|-----|-----------|-----|-----------|-------|--|
| | MO-6843S-1D6-40H | M~H | 3 | 6 | 5.0+2.0 | 3.0 | 3 | 3.8 | 1:0.7~1:2 | 6.5 | DCx27 #11 | 7,000 | |
| | MO-6843S-2D6-40H | | 3 | 6 | 3.0+2.0 | 3.0 | 3 | 3.8 | 1:0.7~1:2 | 6.5 | DCx27 #11 | 7,000 | |

*"sti/min" stands for "Stitches per Minute."

Sewn product pictogram

