

**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

High-speed, Overlock / Safety Stitch Machine

**SERIES**

# 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.



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



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

## DEVICES AND ATTACHMENTS

Model	Part No.	Description
<b>Chain-off thread trimming device</b>		
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
<b>Gathering device</b>			
S206	70000089	Swing-type gathering device (interlocked with pedal / for overlock machine)	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)(DF6)	
S208	70000091	Swing-type gathering device (interlocked with pedal / for safety stitch machine)(FF6)	

### Guide, tape guide

Model	Part No.	Description	Feature
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)	Overedging 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	Anti-material-slip
	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	
	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

UNDER SHIRTS	T-SHIRTS	TROUSERS	ONE-PIECE	SKIRT	DRESS SHIRTS	BLOUSE	POLO SHIRTS	JUMPER	SPORTS WEAR	PAJAMA	KNIT SHIRTS	KNIT WEAR	SUIT	COAT	JEANS	HANDKERCHIEF	SCARF

# 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	DC×27 (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				

MO68□□S□□□□□□/□□□□□□□□

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



**JUKI CORPORATION**  
 SEWING MACHINERY 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.

Keystone Sewing Machine Company, Inc.  
 833 N 2nd Street, Philadelphia, PA 19123 USA  
[www.keysew.com](http://www.keysew.com)  
 215/922.6900  
[info@keysew.com](mailto:info@keysew.com)