

**JUKI®**

*High-speed, overlock / safety stitch machine*

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# *MO-6700S Series*



*MO-6714S*

# MO-6700S Series

*A general-purpose advanced machine that responds to various kinds of sewing materials and processes.*

The MO-6700S 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 is a highly advanced cost-effective machine.



MO-6716S

- *The machine ensures both beautiful and upgraded seam quality at higher speeds.*

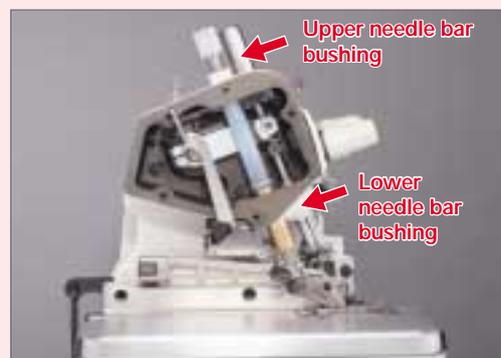
Since the machine comes with a needle-thread take-up mechanism as well as a looper thread take-up mechanism, to offer upgraded responsiveness from light- to heavy-weight materials with a lower applied tension, it achieves well-tensed soft-feeling seams that flexibly correspond to the elasticity of the material at the maximum sewing speed of 7,000rpm.



● Runstitching in general fabric  
MO-6714S-BE6-307

- *Further increased reliability.*

The newly adopted upper and lower needle bar bushings of the needle bar mechanism improve both the durability and reliability of the needle bar unit. The machine comes standard with a cartridge type oil filter and cooling fan for further improved reliability and durability.



- *The machine has been developed with the intention of providing an extended service life.*

The machine incorporates various mechanisms as standard, such as a differential-feed micro-adjustment mechanism and an external adjustment mechanism for adjusting the feed dog inclination as well as increasing the differential feed ratio, which can be easily adjusted to finish seams that perfectly match the material to be used. Comfortable operation is all but guaranteed, by a wider area around the needle entry, the adoption as standard of a micro-lifter feature that offers improved responsiveness to materials and provides the operator with upgraded operability, and by the reduction of operating noise and vibration, which has been achieved by designing an optimally balanced machine.



Differential-feed  
micro-adjustment  
mechanism



Micro-lifter

- *Devices intended for conventional JUKI machines are also interchangeable.*

Gauges and devices you have used with your existing JUKI machines are also interchangeable with no additional machining. This eliminates both the waste of resources and unwanted extra costs.



# SUBCLASS MACHINE LIST

 Seams	 Model No.	 Materials	 Number of needles	 Number of threads	 Needle gauge (mm)	 Overedging width (mm)	 Number of feed dog rows	 Stitch length (mm)	 Bottom differential-feed ratio	 Presser lifting amount (mm)	 Needle system	 Max. sewing speed (rpm)	Remarks
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## < 1-needle overlock >

● For runstitching in general fabric



	MO-6704S-0D4-300	L ~ M	1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000		
	MO-6704S-0E4-300		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000		
	MO-6704S-0F4-300		1	3	-	4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000		
	MO-6704S-0D6-300		1	3	-	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000		
	MO-6704S-0F6-300		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000		
	MO-6704S-0D4-3F0		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000		For soft-chains
	MO-6704S-0E4-3F0		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000		
	MO-6704S-0D6-3F0		1	3	-	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000		
	MO-6704S-0D4-3F6	1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000			
	MO-6704S-0E4-4FH	M ~ H	1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	For soft-chains Upper looper extra high throw type	
	MO-6704S-0E4-40H		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	Upper looper extra high throw type	
	MO-6704S-0F4-40H		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000		
	MO-6704S-0E6-40H		1	3	-	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	Upper looper extra high throw type	
	MO-6704S-0F6-500		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #14	7,000		
MO-6704S-0F6-50H	1		3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #14	7,000			

● For blind hemming

L121: Blind stitch hemming attachment



	MO-6705S-0D4-210/ L121	L ~ M	1	3	-	3.2	2	4	1:0.7 ~ 1:2	5.5	DC x 27 #9	7,000	Upper looper extra high throw type
	MO-6705S-0E4-41H/ L121	M ~ H	1	3	-	4.0	2	4	1:0.7 ~ 1:2	5.5	DC x 27 #9	7,000	

● For rolled hemming (folded downward)



	MO-6704S-0A4-150	EL ~ L	1	3	-	1.6	2	4	1:0.7 ~ 1:2	5	DC x 1 #8	7,000	
	MO-6704S-0A5-150		1	3	-	1.6	1	4	1:0.7 ~ 1:2	5	DC x 1 #8	7,000	

## < 2-needle overlock >

● For runstitching in general fabric



	MO-6714S-BD4-307	L ~ M	2	4	2.0	3.2	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6714S-BE4-307		2	4	2.0	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6714S-BD6-307		2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6714S-BE6-307		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6714S-BE6-20H		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6714S-BE4-40H	M ~ H	2	4	2.0	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	Upper looper extra high throw type
	MO-6714S-BE6-40H		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6712S-CE4-40H		2	4	2.4	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	For imitation safety-stitching
	MO-6712S-DF6-507		2	4	3.2	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #14	7,000	
	MO-6712S-DF6-50F		2	4	3.2	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #14	7,000	

● For gathering

S162: Swing-type gathering device (manual-lever operated)



	MO-6714S-BE6-327/ S162	L ~ M	2	4	2.0	4.0	3	3.2	1:0.9 ~ 1:2.6	6	DC x 27 #11	7,000	
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● For tape attaching

G02, G39: Tape attaching presser foot    Q141: Tape guide



	MO-6714S-BE6-44H/ G39/Q141	M ~ H	2	4	2.0	4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	Upper looper extra high throw type
	MO-6714S-BE7-44H/ G02/Q141		2	4	2.0	4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	

Seams	Model No.	Materials	Number of needles	Number of threads	Needle gauge (mm)	Overredging width (mm)	Number of feed dog rows	Stitch length (mm)	Bottom differential-feed ratio	Presser lifting amount (mm)	Needle system	Max. sewing speed (rpm)	Remarks
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### < Safety stitching >

#### ● For runstitching in general fabric



	MO-6716S-DD6-300	L ~ M	2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-DD6-3F0		2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	For soft-chains
	MO-6716S-DE4-300		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-DE6-300		2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-FF6-300		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-BE4-40H	M ~ H	2	5	2.0	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	Upper looper extra high throw type
	MO-6716S-DE4-40H		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-DE6-40H		2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-FF6-40H		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-DD6-500		2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,000	
	MO-6716S-FF6-500		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,000	
	MO-6716S-FF6-50H		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #16	7,000	Upper looper extra high throw type
	MO-6716S-FH6-50H		2	5	4.8	6.4	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #16	7,000	
	MO-6716S-FF6-60H	H	2	5	4.8	4.8	3	4.5	1:0.9 ~ 1:1.7	5	DC x 27 #21	7,000	For jeans
	MO-6716S-FH6-60H		2	5	4.8	6.4	3	4.5	1:0.9 ~ 1:1.7	5	DC x 27 #21	7,000	Upper looper extra high throw type

#### ● For gathering S159: Swing-type gathering device (interlocked with pedal) S161: Swing-type gathering device (manual-lever operated)



	MO-6716S-FF6-42H/S159	M ~ H	2	5	4.8	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC x 27 #14	7,000	Upper looper extra high throw type
	MO-6716S-DE4-42H/S161		2	5	3.2	4.0	2	3.2	1:0.9 ~ 1:2.6	6	DC x 27 #11	7,000	

#### ● For rolling-in tape N077: Clean finish top and bottom



	MO-6745S-ED4-360/N077	L ~ M	2	4	4.0	3.2	2	4	1:0.7 ~ 1:2	5	DC x 27 #14	7,000	2-needle type for double-chainstitch on pocket bags
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### < 3-needle safety stitching >



	MO-6743S-1D6-40H	M ~ H	3	6	4.8 + 2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	Upper looper extra high throw type
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## SUBCLASS

Diversified subclass machines are available. The selection of a machine that best matches the processes in concern are permitted.



● Blind hemming  
MO-6705S-0E4-41H/L121  
(L121: Blind stitch hemming attachment)



● For gathering  
MO-6714S-BE6-327/S162  
(S162: Swing-type gathering device)



● For rolling-in tape  
MO-6745S-ED4-360/N077  
(N077: Clean finish top and bottom)

# MO-6700S Series

## DEVICES AND ATTACHMENTS

Model	Part No.	Description		
<b>● Chain-off thread trimming device</b>				
T039	MAT-039001A0	One-touch type tape cutter and chain-off thread trimming device (electromagnetic type)		
	MAT-039002A0	For 110, 115, 220, 240V For 220, 380, 415, 440V		
T040	MAT-040001A0	Automatic tape cutter + chain-off thread trimming device (number-off-stitch control and electromagnetic type)	For semi-sunken type	For 110, 115, 220, 240V For 220, 380, 415, 440V
	MAT-040002A0		For fully-sunken type	For 110, 115, 220, 240V For 220, 380, 415, 440V
	MAT-040001AA	Pneumatic flat cutter	For 110, 115, 220, 240V	For 220, 380, 415, 440V
	MAT-040002AA		Pneumatic side cutter	
T041	MAT-041000A0A			
T042	MAT-042000A0			

<b>● Blower-type chain-off thread suction device</b>		
MC-7A		Blower-type chain-off thread suction device + cloth chips

<b>● Pneumatic chain-off thread suction device</b>		
MC-4		Specific to chain-off thread, pedal-operated
MC-5		Specific to chain-off thread
MC-8		Pneumatic chain-off thread + cloth chips
MC-9		Function of MC-8 + auto-lifter
MC-24		Pneumatic chain-off thread + cloth chips

\* The aforementioned devices are not equipped with an air regulator.  
Please purchase the following components when you need to regulate air pressure.

	PF-0522010-B0	Air regulator (F.R. unit asm.)
	GMD-01080000 × 2	Fixing screw for F.R. unit asm.
	F1021-003-000	Tube connector (male)
	GAS-12063000 *	One-touch connector * Selection parts instead of the tube connector

<b>● Auto-lifter</b>		
AK25	GAK-250000A0	Electromagnetic type
AK32	GAK-320000A0	Pneumatic type (knee-operated)
AK49	GAK-490000A0	Pneumatic type (pedal-operated)
AK52	GAK-520000A0	Pneumatic type (with chain-off thread suction device)
AK65	GAK-650000A0	Electromagnetic type
AK101	GAK-A01000A0	Pneumatic type (for servomotor)

Model	Part No.	Description	Feature
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<b>● Gathering device</b>			
S159	MAS-159000A0	Swing-type gathering device (interlocked with pedal / for safety stitch machine)	The attachment opens with the presser foot pedal. This facilitates material setting on the machine. Furthermore, a knee-control type differential-feed adjusting device is built in the attachment. It controls a differential-feed ratio as desired, thereby enabling the operator to make beautiful gathers.
S160	MAS-160000A0	Swing-type gathering device (interlocked with pedal / for overlock machine)	
S161	MAS-161000A0	Swing-type gathering device (manual-lever operated / for safety stitch machine)	The attachment is used to perform two different processes, joining fabric process and gathering process, at a time.
S162	MAS-162000A0	Swing-type gathering device (manual-lever operated / for overlock machine)	The attachment can be opened/closed by using the lever (manually operated). The differential-feed ratio is controlled with the knee lever.

<b>● Blind hemming device</b>				
L121	MAL-121000A0	Blind stitch hemming attachment	A ruler used for blind hemming in knits	
L122	MAL-122001A0	Automatic folded-edge controlled blind hemming device	For flat upper knife	For 110, 115, 220, 240V
	MAL-122002A0		For 220, 380, 415, 440V	
	MAL-122001AA		For 110, 115, 220, 240V	
	MAL-122002AA		For 220, 380, 415, 440V	
L123	MAL-123000A0	Spring-type folded-edge controlled bottom hemming device	When the overlapped section of a material is reached, the blind hemming guide will move sufficiently to prevent stitch deviation.	

<b>● Piping folder</b>			
M056	MAM-0560J0A0	Piping folder	This piping folder makes a piping first, then turns up the tape.
M075	MAM-0750J0A0	Piping folder (to be used with knit tape)	This attachment can be used for both "cotton bias tape with gimp" and "knit tape". The operation mode can be changed over with a fingertip control.
M076	MAM-0760N0A0	Ready-made piping folder	The dimension of ready-made tapes can be adjusted within the range of 8 to 13mm.
M077	MAM-0770M0A0	Piping folder for gathering	The attachment makes gathers on the lower fabric while making decorative piping.

<b>● Guide, Ruler</b>			
H153	MAH-153000A0	Cloth edge guide ruler (for overlock machine)	A swing type edge guide.
H154	MAH-154000A0	Cloth edge guide ruler (for safety stitch machine)	
Q141	MAQ-141000B0	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.
S084D	MAS-084000AD	Pattern guide	This attachment is used for overedging a sleeve bottom placket with a sharp curve. It enables the machine to smoothly sew the curved section of a sleeve bottom placket along with the guide pin of the presser foot.

<b>● Feller, Binder</b>			
K006	MAK-00601000	Upturn feller	This feller is exclusively used with the 3C0 throat plate. It is attached on the throat plate.
N067	MAN-0670D0A0	Reinforcement tape attachment binder	This binder binds the edge of a pocket bag while cutting round its periphery.
N077	MAN-077000A0	Clean finish top and bottom	This binder runstitches a pocket bag and binding its periphery with tape simultaneously.

<b>● Miscellaneous</b>			
Z173	MAZ-173000A0	Backlatch device (for 1-needle overlock machine)	It sews chain-off thread at the start of sewing inside overedged seam. With this device, the operator is no longer required to neatly arrange the chain-off thread. Rolled-in chain-off thread also works as a simplified bartack.
	131-62557	Needle cooler unit asm.	Needle cooler By silicon oil lubricating unit for the needle thread.
	SS-4091015SP	Screw	
	WP-0371026SD	Washer	
	SS-7110840SP	Screw	
	131-63159	Needle cooler unit asm.	
	SS-4091015SP	Screw	
	131-63159	Needle cooler unit asm.	Needle thread heat remover By silicon oil lubricating unit for the needle thread.
	SS-4091015SP	Screw	
	WP-0371026SD	Washer	
	131-63902	Presser	
	131-63456	Silicon tank asm.	
	131-63803	Felt	
	TA-0950806R0	Rubber plug	
	SM-4040855SP	Screw	

### [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
T039	MC-7A	AK65 (Electronic-stop motor or AC servomotor)
		AK101 (JUKI servomotor)
	MC-8	AK65 (Electronic-stop motor or AC servomotor)
T040	MC-7A	AK32 (any motor will do)
		AK65 (Electronic-stop motor or AC servomotor)
T041 or T042	MC-7A	AK49 (Motors other than JUKI servomotors are applicable.)
		AK65 (Electronic-stop motor or AC servomotor)
	MC-8	AK65 (Electronic-stop motor or AC servomotor)

T040	MC-7A	AK32 (any motor will do)
		AK65 (Electronic-stop motor or AC servomotor)
	MC-5	AK32 (any motor will do)
T041 or T042	MC-7A	AK49 (Motors other than JUKI servomotors are applicable.)
		AK65 (Electronic-stop motor or AC servomotor)
MC-8	AK65 (Electronic-stop motor or AC servomotor)	

T041 or T042	MC-7A	AK49 (Motors other than JUKI servomotors are applicable.)
		AK65 (Electronic-stop motor or AC servomotor)
	MC-8	AK65 (Electronic-stop motor or AC servomotor)

