

**JUKI®**

# MO-6700S Series

High-speed, Overlock / Safety Stitch Machine



*MO-6714S*

# *MO-6700S Series*

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

# 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.***

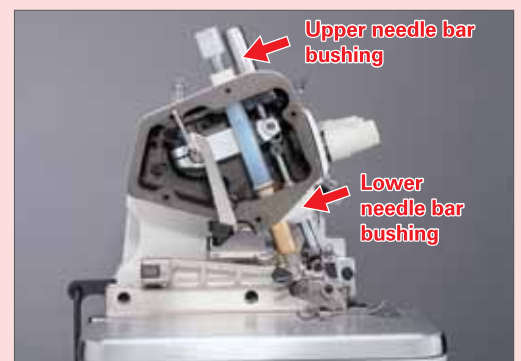
Since the machine comes with a needle-thread take-up mechanism as well as a looper thread take-up mechanism, to offer upgraded responsiveness from light- to heavy-weight materials with a lower applied tension, it achieves well-tensed soft-feeling seams that flexibly correspond to the elasticity of the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



● **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)	Overredging width (mm)	Number of feed dog rows	Stitch length (mm)	Bottom differential-feed ratio	Presser lifting amount (mm)	Needle system	Max. sewing speed (sti/min*)	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	DCx27 #11	7,000	
	MO-6704S-0E4-300		1	3	-	4.0	2	4	1:0.7~1:2	7	DCx27 #11	7,000	
	MO-6704S-0F4-300		1	3	-	4.8	2	4	1:0.7~1:2	7	DCx27 #11	7,000	
	MO-6704S-0D6-300		1	3	-	3.2	3	4	1:0.7~1:2	7	DCx27 #11	7,000	
	MO-6704S-0F6-300		1	3	-	4.8	3	4	1:0.7~1:2	7	DCx27 #11	7,000	
	MO-6704S-0E4-40H	M~H	1	3	-	4.0	2	4	1:0.7~1:2	7	DCx27 #11	7,000	Upper looper extra high throw type
	MO-6704S-0F4-40H		1	3	-	4.8	2	4	1:0.7~1:2	7	DCx27 #11	7,000	
	MO-6704S-0E6-40H		1	3	-	4.0	3	4	1:0.7~1:2	7	DCx27 #11	7,000	
	MO-6704S-0F6-50H		1	3	-	4.8	3	4	1:0.7~1:2	7	DCx27 #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	DCx27 #9	7,000	
	MO-6705S-0E4-41H/L121	M~H	1	3	-	4.0	2	4	1:0.7~1:2	5.5	DCx27 #9	7,000	Upper looper extra high throw type

### For rolled hemming (folded downward)



	MO-6704S-0A4-150	EL~L	1	3	-	1.6	2	4	1:0.7~1:2	5	DCx1 #8	7,000	
	MO-6704S-0A5-150		1	3	-	1.6	1	4	1:0.7~1:2	5	DCx1 #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	DCx27 #11	7,000	Upper looper high throw type	
	MO-6714S-BE4-307		2	4	2.0	4.0	2	4	1:0.7~1:2	6.5	DCx27 #11	7,000		
	MO-6714S-BD6-307		2	4	2.0	3.2	3	4	1:0.7~1:2	6.5	DCx27 #11	7,000		
	MO-6714S-BE6-307		2	4	2.0	4.0	3	4	1:0.7~1:2	6.5	DCx27 #11	7,000		
	MO-6714S-BE6-207		2	4	2.0	4.0	3	4	1:0.7~1:2	6.5	DCx27 #9	7,000		
	MO-6714S-BE6-20H	M~H	2	4	2.0	4.0	3	4	1:0.7~1:2	6.5	DCx27 #9	7,000	Upper looper extra high throw type	
	MO-6714S-BE4-40H		2	4	2.0	4.0	2	4	1:0.7~1:2	6.5	DCx27 #11	7,000		
	MO-6714S-BE6-40H		2	4	2.0	4.0	3	4	1:0.7~1:2	6.5	DCx27 #11	7,000		
	MO-6712S-CE4-40H		2	4	2.4	4.0	2	4	1:0.7~1:2	6.5	DCx27 #11	7,000		
	MO-6712S-DF6-507		2	4	3.2	4.8	3	4	1:0.7~1:2	6.5	DCx27 #14	7,000		For imitation safety-stitching
	MO-6712S-DF6-50F		2	4	3.2	4.8	3	4	1:0.7~1:2	6.5	DCx27 #14	7,000		For swimsuit

### 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	DCx27 #11	7,000	
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### For tape attaching ★G02, G39: Tape attaching presser foot ★Q141: Tape guide



	MO-6714S-BD6-347/G39/Q141	L~M	2	4	2.0	3.2	3	3.2	1:0.7~1:2	7	DCx27 #11	7,000	Upper looper high throw type
	MO-6714S-BD6-24H/G39/Q141		2	4	2.0	3.2	3	3.2	1:0.7~1:2	7	DCx27 #9	7,000	
	MO-6714S-BE6-24H/G39/Q141		2	4	2.0	4.0	3	3.2	1:0.7~1:2	7	DCx27 #9	7,000	
	MO-6714S-BD6-34H/G39/Q141	M~H	2	4	2.0	3.2	3	3.2	1:0.7~1:2	7	DCx27 #11	7,000	Upper looper extra high throw type
	MO-6714S-BE6-34H/G39/Q141		2	4	2.0	4.0	3	3.2	1:0.7~1:2	7	DCx27 #11	7,000	
	MO-6714S-BE6-44H/G39/Q141		2	4	2.0	4.0	3	3.2	1:0.7~1:2	7	DCx27 #14	7,000	
	MO-6714S-BE7-44H/G02/Q141		2	4	2.0	4.0	4	3.2	1:0.7~1:2	7	DCx27 #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 (sti/min*)	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	DCx27 #11	7,000			
	MO-6716S-DE4-300		2	5	3.2	4.0	2	4	1:0.7~1:2	7	DCx27 #11	7,000			
	MO-6716S-DE6-300		2	5	3.2	4.0	3	4	1:0.7~1:2	7	DCx27 #11	7,000			
	MO-6716S-FF6-300		2	5	4.8	4.8	3	4	1:0.7~1:2	7	DCx27 #11	7,000			
	MO-6716S-BE4-40H	M~H	2	5	2.0	4.0	2	4	1:0.7~1:2	7	DCx27 #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	DCx27 #11	7,000			
	MO-6716S-DE4-40H/E35		2	5	3.2	4.0	2	4	1:0.7~1:2	7	DCx27 #11	7,000			
	MO-6716S-DE6-40H		2	5	3.2	4.0	3	4	1:0.7~1:2	7	DCx27 #11	7,000			
	MO-6716S-FF6-40H		2	5	4.8	4.8	3	4	1:0.7~1:2	7	DCx27 #11	7,000			
	MO-6716S-DF6-50H		2	5	3.2	4.8	3	4	1:0.7~1:2	6.5	DCx27 #16	7,000			
	MO-6716S-FF6-50H		2	5	4.8	4.8	3	4	1:0.7~1:2	6.5	DCx27 #16	7,000			
	MO-6716S-FH6-50H		2	5	4.8	6.4	3	4	1:0.7~1:2	6.5	DCx27 #16	7,000			
	MO-6716S-FF6-60H		H	2	5	4.8	4.8	3	4.5	1:0.9~1:1.7	5	DCx27 #21		7,000	For jeans Upper looper extra high throw type
	MO-6716S-FH6-60H			2	5	4.8	6.4	3	4.5	1:0.9~1:1.7	5	DCx27 #21		7,000	

#### ● 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	DCx27 #14	7,000	Upper looper extra high throw type
	MO-6716S-DE4-42H/S161		2	5	3.2	4.0	2	3.2	1:0.7~1:2	6	DCx27 #11	7,000	
	MO-6716S-DF6-42H/S161		2	5	3.2	4.8	3	3.2	1:0.7~1:2	6	DCx27 #11	7,000	

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



	MO-6745S-FF4-360/N077	L~M	2	4	4.8	4.8	2	4	1:0.7~1:2	5	DCx27 #11	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	DCx27 #11	7,000	Upper looper extra high throw type
	MO-6743S-1D6-50H		3	6	4.8 +2.0	3.2	3	4	1:0.7~1:2	6.5	DCx27 #11	7,000	
	MO-6743S-2D6-40H		3	6	3.2 +2.0	3.2	3	4	1:0.7~1:2	6.5	DCx27 #11	7,000	

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

## 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	400-44155	One-touch type tape cutter and chain-off thread trimming device (electromagnetic type)
	400-44156	
T040	400-43894	Automatic tape cutter + chain-off thread trimming device (number-off-stitch control and electromagnetic type)
	400-43897	
	400-43898	For semi-sunken type
	400-43899	For fully-sunken type
T041S	400-75885	Pneumatic flat cutter
T042S	400-45967	Pneumatic side cutter

Model	Part No.	Description
<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 air regulator.  
Please purchase the following components when you need to regulate air pressure.

—	PF-0552010-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

Model	Part No.	Description
<b>Auto-lifter</b>		
AK32	GAK-320000A0	Pneumatic type (knee-operated)
AK49	GAK-490000A0	Pneumatic type (pedal-operated)
AK101	GAK-A01000A0	Pneumatic type (for servomotor)

Model	Part No.	Description	Feature
<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, 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. The attachment can be opened/closed by using the lever (manually operated). The differential-feed ratio is controlled with the knee lever.
S162	MAS-162000A0	Swing-type gathering device (manual-lever operated / for overlock machine)	

<b>Blind hemming device</b>			
L121	MAL-121000A0	Blind stitch hemming attachment	A ruler used for blind hemming in knits
L123	MAL-123000A0	Spring-type folded-edge controlled blind hemming ruler	The bottom ruler moves by a necessary amount when a multi-layered part of material is reached to prevent stitch deviations.

<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.

<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.

<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 (finished width: 4mm)	This binder binds the edge of a pocket bag while cutting round its periphery.
N077	MAN-0770F0A0	Binder for clean finish top and bottom	With the binder, the machine simultaneously sews a pocket bag to the front and binds tape to it.

<b>Miscellaneous</b>			
Z173	MAZ-17301000×1 MAZ-082000C0×1 119-22556×1	Pneumatic chain-off thread suction device (for 1-needle machines)	Simplified device for tucking chain-off thread sewn at the beginning of sewing in overlocked seams. (chain-off thread upper clamping method)
Z195	400-33882	Pneumatic chain-off thread suction device (for 1-needle machines)	Simplified device for tucking chain-off thread sewn at the beginning of sewing in overlocked seams. (chain-off thread lower clamping method)
—	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	
—	131-63902	Presser	Needle thread heat remover By silicon oil lubricating unit for the needle thread.
	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-8	AK101 (JUKI servomotor)
	MC-9	— (MC-9 is equipped with auto-lifter.)

T040	MC-5	AK32 (any motor will do)
	MC-24	AK32 (any motor will do)

T041S or T042S	MC-4	—
	MC-8	AK101 (JUKI servomotor)
	MC-9	— (MC-9 is equipped with auto-lifter.)

# SPECIFICATIONS

Model name	MO-6704S	MO-6714S	MO-6716S
Stitch type	1-needle overlock	2-needle overlock	Safety stitching
Stitch style in the U.S.A.	504	514	516
Max. sewing speed	7,000sti/min*		
Stitch length	0.8~4mm		1.5~4mm
Needle gauge (mm)	—	2.0, 2.4, 3.2	2.0, 3.2, 4.0, 4.8, 4.8+2.0
Overedging width (mm)	1.6, 3.2, 4.0, 4.8	3.2, 4.0, 4.8	3.2, 4.0, 4.8, 6.4
Differential feed ratio	For gathering 1:2 (max. 1:4); For stretching 1:0.7 (max. 1:0.6)		
Needle bar stroke	24.5mm		
Inclination angle of the needle	20°		
Needle mechanism	Needle bar method and upper/lower bushing		
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	28kg		
Lubrication	Automatic		
Lubricating oil	JUKI Machine Oil 18 (equivalent to ISO VG18)		
Needle cooler	Option		
Needle thread heat remover	Option		
Micro-lifter	Provided as standard		

\* "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
1-needle overlock	504	04
1-needle overlock for blind hemming	505	05
2-needle imitation safety stitch	512	12
2-needle overlock	514	14
2-needle safety stitch	516	16
3-needle safety stitch		43
2-needle double chain stitch		45

Type	Code
Standard	S

Device and attachment	Code
Tape attaching presser foot / Tape guide	G02/Q141
Tape attaching presser foot (for sewing sharp curves)/ Tape guide	G39/Q141
Blind stitch hemming attachment	L121
Swing-type gathering device (interlocked with pedal / for safety stitch machine)	S159
Swing-type gathering device (manual-lever operated / for safety stitch machine)	S161
Swing-type gathering device (manual-lever operated / for overlock machine)	S162
Clean finish top and bottom	N077

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Needle gauge (mm)	Overedging width (mm)	Feed dog	Code
—	1.6	2-row	0A4
—	1.6	1-row	0A5
—	3.2	2-row	0D4
—	3.2	3-row	0D6
—	4.0	2-row	0E4
—	4.0	3-row	0E6
—	4.8	2-row	0F4
—	4.8	3-row	0F6
2.0	3.2	2-row	BD4
2.0	3.2	3-row	BD6
2.0	4.0	2-row	BE4
2.0	4.0	3-row	BE6
2.0	4.0	4-row	BE7
2.4	4.0	2-row	CE4
3.2	3.2	3-row	DD6
3.2	4.0	2-row	DE4
3.2	4.0	3-row	DE6
3.2	4.8	3-row	DF6
4.0	3.2	2-row	ED4
4.8	4.8	3-row	FF6
4.8	6.4	3-row	FH6
4.8+2.0	3.2	3-row	1D6
3.2+2.0	3.2	3-row	2D6

Material		Application	Special machine classification	Code		
Extra light- to light-weight	Light-weight materials such as men's shirts	Rolled hemming	Standard	150		
		Light- to medium-weight	Specific to knits	Runstitching	Upper looper extra high throw	20H
				Blind hemming	Standard	210
Light- to medium-weight	For general fabrics	Runstitching	Standard	300		
		Runstitching	Upper looper high throw	307		
		Gathering	Upper looper high throw	327		
		Rolling-in tape	Standard	360		
		Soft-chain	Standard	3F0		
		Soft-chain	Throat plate and feed dog both provided with a lip	3F6		
		Medium- to heavy-weight	Specific to knits such as sweaters	Runstitching	Upper looper extra high throw	40H
				Blind hemming	Upper looper extra high throw	41H
				Gathering	Upper looper extra high throw	42H
				Tape attaching	Upper looper extra high throw	44H
				Soft-chain	Upper looper extra high throw	4FH
				Runstitching	Standard	500
Medium- to heavy-weight materials such as denim		Runstitching	Upper looper high throw	507		
		Runstitching	Swim suits	50F		
		Runstitching	Upper looper extra high throw	50H		
		Runstitching	Upper looper extra high throw	60H		
For heavy-weight materials		Runstitching	Upper looper extra high throw			

● To order, please contact your nearest JUKI distributor.



### JUKI CORPORATION HEAD OFFICE

Juki Corporation operates an environmental management system to promote and conduct the following as the company engages in the research, development, design, sales, distribution and maintenance of industrial sewing machines, household sewing machines, industrial robots, etc., and in the provision of sales and maintenance services for data entry systems:

- (1) The development of products and engineering processes that are safe to the environment
- (2) Green procurement and green purchasing
- (3) Energy conservation (reduction in carbon-dioxide emissions)
- (4) Resource saving (reduction of papers purchased, etc.)
- (5) Reduction and recycling of waste
- (6) Improvement of logistics efficiency (modal shift and improvement of packaging, pecking, etc.)

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\* 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 soy ink on recycle paper.