

**JUKI®**

Dry-head, High-speed, Overlock / Safety Stitch Machine

# ***MO-6100D Series***

*The World's First*



**MO-6114D**



# MO-6100D Series

## THE WORLD'S FIRST DRY-HEAD OVERLOCK MACHINE!

JUKI's technology for developing machines that require no oiling has created an overlock machine with a maximum sewing speed of 6,000rpm. This overlock machine is capable of responding to the need for both high-grade and high-quality sewing performance.



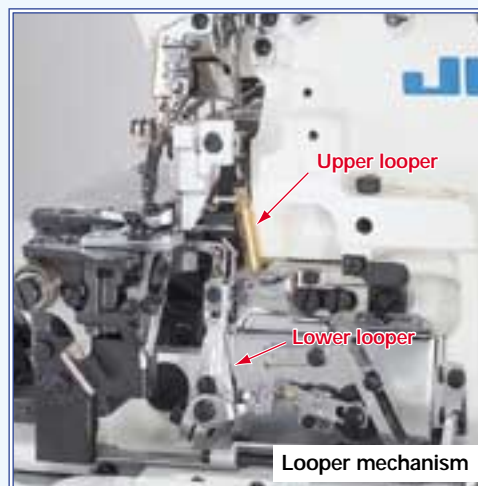
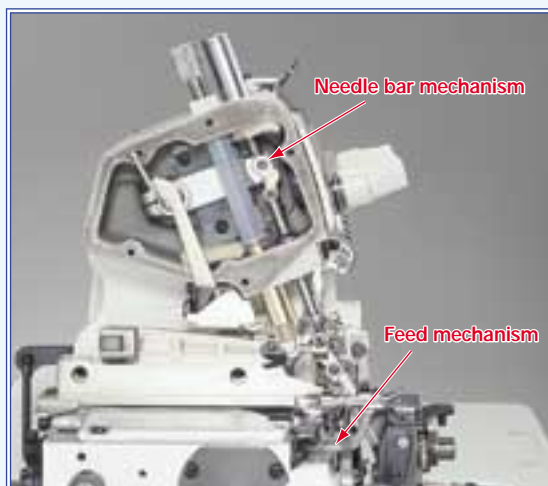
MO-6114D



MO-6104D

### Oil stains on the sewing product are eliminated.

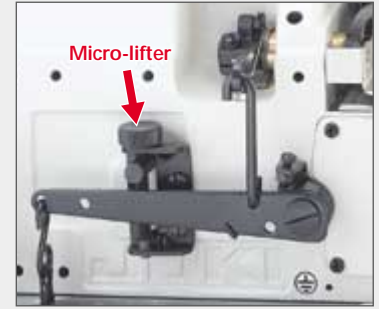
- The needle bar, feed and looper mechanisms require no oiling. This means they do not splash oil, thereby leaving no oil stains on the sewing material, and thus contributing to upgraded quality.
- Stain-removing work or re-sewing work resulting from oil stains is eliminated.
- The machine does not need periodical oiling or used-oil disposal, which markedly improves maintainability.



- The driving section of the machine, except for the needle bar, feed and looper mechanisms is installed in a forced oiling block. This block is completely sealed to prevent the leakage of oil.

## 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.



## Operability is further improved.

- The stitch length can be easily adjusted with the push-button mounted on the front surface of the sewing machine. Opening of the cloth plate cover is no longer required for stitch length adjustments.



## 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 required. This eliminates both the waste of resources and unwanted extra costs.

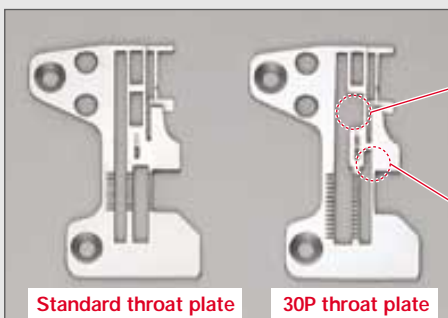


# Anti-material-slip type

The sewing machine is fully equipped with adjusting devices and provisions to effectively prevent puckering of difficult-to-sew materials or new-generation materials. The operator is able to produce beautifully finished high-quality seams without conducting difficult adjustments.

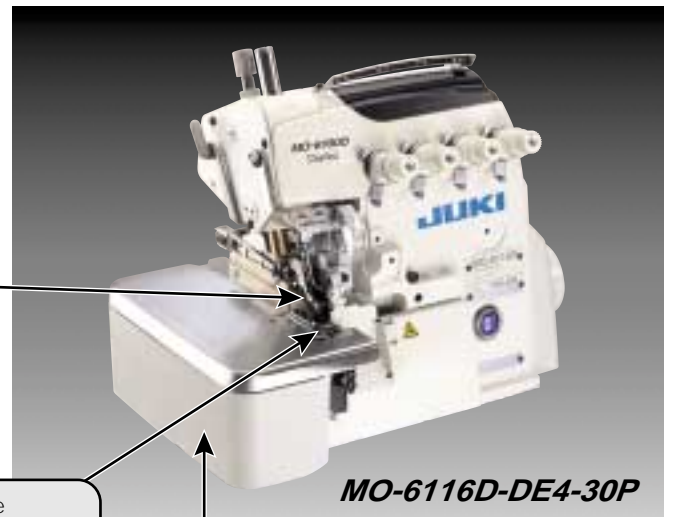
- The locus of feed and feed timing are selected to offer optimum conditions for sewing light-weight materials.
- The machine comes as standard with a low-pressure presser foot that is exclusively designed for light-weight materials and is able to remarkably handle small curves of the material. The presser foot helps the operator control lighter-weight material smoothly on the machine.

- By the use of the specifically developed throat plate and feed dog, the double chainstitch looper thread feeding mechanism demonstrates superb effectiveness in preventing puckering of the material caused by the feed mechanism as well as puckering appearing between stitches.



The throat plate, with its increased surface area, helps prevent puckering.

In addition to the increased throat plate area, the exclusive feed dog helps prevent puckering of the material between stitches.
















- The feed mechanism feeds double chainstitch looper thread with consistency, even under a low tension. (Safety stitch machine)



MO-6114D-30P  
MO-6116D-30P

# 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-6104D-0D4-40H	M ~ H	1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	Upper looper extra high throw type
	MO-6104D-0E4-40H		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6104D-0D6-40H		1	3	-	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6104D-0E6-40H		1	3	-	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6104D-0F4-40H		1	3	-	4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6104D-0F6-40H		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	

## <2-needle overlock>

● For runstitching in general fabric




	MO-6114D-BD4-40H	M ~ H	2	4	2.0	3.2	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	Upper looper extra high throw type
	MO-6114D-BD6-40H		2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	
	MO-6114D-BE4-40H		2	4	2.0	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	
	MO-6114D-BE6-40H		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	
	MO-6114D-BB6-30P	L ~ M	2	4	2.0	2.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	Anti-material-slip
	MO-6114D-BD6-30P		2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	
	MO-6114D-BE6-30P		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	
	MO-6114D-CF6-40H	M ~ H	2	4	2.4	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	Upper looper extra high throw type

● For tape attaching

G39: Tape attaching presser foot    Q141: Tape guide




	MO-6114D-BE6-44H/ G39/Q141	M ~ H	2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #14	6,000	Upper looper extra high throw type
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## <Safety stitching>

● For runstitching in general fabric



	MO-6116D-DE4-40H	M ~ H	2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	Upper looper extra high throw type
	MO-6116D-DE6-40H		2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-DF4-40H		2	5	3.2	4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-DF6-40H		2	5	3.2	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-FF6-40H		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-BE4-30P	L ~ M	2	5	2.0	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	Anti-material-slip
	MO-6116D-BF4-30P		2	5	2.0	4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-DD4-30P		2	5	3.2	3.2	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-DE4-30P		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-DF4-30P		2	5	3.2	4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-FF4-30P		2	5	4.8	4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	



# 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 electro-magnetic type)
	MAT-040002A0	For semi-sunken type
	MAT-040001AA	For 110, 115 ,220, 240V
	MAT-040002AA	For fully-sunken type For 220, 380, 415, 440V
T041	MAT-041000A0A	Pneumatic flat cutter
T042	MAT-042000A0	Pneumatic side cutter

<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-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

<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
	MAL-122002A0		For 110, 115 ,220, 240V For 220, 380, 415, 440V
	MAL-122001AA	For square upper knife	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.	For overlock machine
	SS-7110840SP	Screw	
	131-63159	Needle cooler unit asm.	For safety stitch machine
	SS-7110840SP	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-7A	AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)
		MC-8	AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)
		MC-9	(MC-9 is equipped with an auto-lifter.)
T040	+	MC-7A	AK32 (any motor will do) AK65 (Electronic-stop motor or AC servomotor)
		MC-5	AK32 (any motor will do)
		MC-24	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) AK101 (JUKI servomotor)
		*	AK52 (any motor will do) * AK52 is equipped with a chain-off thread suction device.
		MC-4	AK65 (Electronic-stop motor or AC servomotor)
		MC-8	AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)
		MC-9	(MC-9 is equipped with an auto-lifter.)

# SPECIFICATIONS

Model name	MO-6104D	MO-6114D	MO-6116D
Stitch type	1-needle overlock	2-needle overlock	Safety stitching
Stitch style in the U.S.A.	504	514	516
Max. sewing speed	6,000rpm		
Stitch length	0.8 ~ 4mm		1.5 ~ 4mm
Needle gauge (mm)	-	2.0, 2.4	2.0, 3.2, 4.8
Overedging width (mm)	3.2, 4.0, 4.8	2.0, 3.2, 4.0, 4.8	3.2, 4.0, 4.8
Bottom differential feed ratio	For gathering 1:2 (Max. 1:4), For stretching 1:0.7 (Max. 1:0.6)		
Needle bar stroke	24.5mm (Anti-material-slip type), 25.5mm (Upper looper extra high throw type)		
Inclination angle of the needle	20°		
Needle mechanism	Needle bar method and upper/lower bushing		
Needle	DC x 27 (excluding some subclass model)		
Max. lift of the presser foot	7mm (excluding some subclass model)		
Max. presser foot pressure	63.7N (6.5kg)		
Stitch adjusting method	By push-button		
Differential-feed adjusting method	By lever (with micro-adjustment)		
Weight of the machine head	28kg		
Lubrication	No lubrication		
Needle cooler	Option		
Needle thread heat remover	Option		
Micro-lifter	Provided as standard		

## 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	Dry-head	D	Tape attaching presser foot (for sewing sharp curves) / Tape guide	G39/Q141
2-needle overlock	514	14				
2-needle safety stitch	516	16				

**MO61** [ ] [ ] **D** [ ] [ ] [ ] [ ] [ ] [ ] / [ ] [ ] [ ] [ ] [ ] [ ] [ ] [ ]

Needle gauge (mm)	Overedging width (mm)	Feed dog	Code
	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	2.0	3-row	BB6
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
2.4	4.8	3-row	CF6
3.2	3.2	2-row	DD4
3.2	4.0	2-row	DE4
3.2	4.0	3-row	DE6
3.2	4.8	2-row	DF4
3.2	4.8	3-row	DF6
4.8	4.8	2-row	FF4
4.8	4.8	3-row	FF6

Material	Application	Special machine classification	Code
Medium- to heavy-weight	Runstitching	Upper looper extra high throw	40H
	Tape attaching	Upper looper extra high throw	44H
Light- to medium-weight	Runstitching	Anti-material-slip type	30P

● To order, please contact your nearest JUKI distributor.



**JUKI CORPORATION HEAD OFFICE**  
 The environmental management system to promote and conduct  
 ①the technological and technical research, the development and design of the products in which the environmental impact is considered.  
 ②the conservation of the energy and resources, and the recycling, in the research, development, design, distribution, sale and maintenance service of the industrial sewing machines, household sewing machines and industrial-use robots, etc. and in the purchase, distribution and sale of the household commodities including the healthcare products.

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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 catalog is printed on recycle paper.