

JUKI

MO-6800AS/DD10, DD22, DD23

Direct-drive, High-speed, Overlock / Safety Stitch Machine

MO-6800AD/DD10, DD22, DD23

Semi-dry-head, Direct-drive, High-speed, Overlock / Safety Stitch Machine



MO-6816AS/DD23



MO-6814AD/DD23

Features

- The direct drive system has been adopted.
- Both the control box and the operation panel are integrated with the machine head.
- Max. sewing speed 7,000sti/min.
- Lubrication Method:
MO-6800 “AD” is Semi-dry
(needle bar/upper looper no lubrication).

Smart Devices

The cover sensor unit and cover microswitch unit

The cover sensor unit and cover microswitch unit that detect **1**, **2** and **3** (shown right) are closed tightly during sewing, thereby preventing the sewing machine from starting up unexpectedly.



1. Eye guard with an open/close sensor



2. Cloth plate cover with an open/close microswitch



3. Presser foot arm with an open/close sensor

SPECIFICATIONS

Model name	MO-6800AS/DD10,22,23				MO-6800AD/DD10,22,23			
	MO-6804AS	MO-6814AS	MO-6816AS	MO-6843AS	MO-6804AD	MO-6814AD	MO-6816AD	MO-6843AD
Stitch type	1-needle overlock	2-needle overlock	Safety stitching	3-needle safety stitching	1-needle overlock	2-needle overlock	Safety stitching	3-needle safety stitching
Stitch style in the U.S.A.	504	514	516	—	504	514	516	—
Dry type	—	—	—	—	Semi-dry	Semi-dry	Semi-dry	Semi-dry
Max. sewing speed	7,000sti/min (excluding some subclass model)							
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	—	2.0	3.0, 5.0	5.0+2.0
Overedging width (mm)	1.5, 4.0	3.0, 4.0	4.0, 5.0, 6.0	3.0	4.0	2.0, 3.0, 4.0	4.0, 5.0	3.0
Bottom differential feed ratio	Gathering 1:2 (Max. 1:4), Stretching 1: 0.7 (Max. 1:0.6)							
Needle bar stroke	24.5mm (60H: 27mm)							
Inclination angle of the needle	20°							
Needle mechanism	Lower bushing method							
Needle	DCx27 (refer to subclass machine list) / DCx1 (available only on some models)							
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 (The needle bar mechanism and upper looper mechanism do not require lubrication.)							
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							

WHEN YOU PLACE ORDERS

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

Stitch type	Code	Type	Code	Device and attachment	Code	Power supply	Code
1-needle overlock	04	Standard	S	Latch for changing overedging width	E35	Single phase 220~240V	K
2-needle overlock	14	Semi-dry	D	Tape attaching presser foot includes Tape guide	G44	Single phase 220~240V (CE)	N
2-needle safety stitch	16			Piping folder (to be used with knit tape)	N075	Single phase 110~120V	S
3-needle safety stitch	43						

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Needle gauge (mm)	Overedging width (mm)	Feed dog	Code	Material		Application	Special machine	Code	Motor (Device)	Code
—	1.5	2-row	0A4	Extra light- to light-weight	Light-weight materials	Rolled hemming	Standard	150	Direct drive motor	DD10
—	4.0	2-row	0E4	Light- to medium-weight	Specific to knits	Tape attaching	Standard	24H	Direct drive motor (Side cutter with sensor / Automatic foot lifter / Waste removal suction)	DD22
2.0	2.0	3-row	BB6		For general fabrics	Standard	Standard	30H		
2.0	3.0	3-row	BD6			Standard	Anti-material-slip	30P		
2.0	4.0	3-row	BE6			Tape attaching	Standard	34H		
3.0	4.0	2-row	DE4			Rolling-in tape	Standard	360	Direct drive motor (Tape cutter with sensor / Automatic foot lifter / Waste removal suction)	DD23
3.0	4.0	3-row	DE6	Medium- to heavy-weight	Specific to knits such as sweaters	Standard	Standard	40H		
5.0	5.0	3-row	FF6		Medium- to heavy-weight materials such as denim	Tape attaching	Standard	44H		
5.0	6.0	3-row	FH6			Standard	Standard	50H		
5.0+2.0	3.0	3-row	1D6		heavy-weight	heavy-weight	Standard	Standard		
3.0+2.0	3.0	3-row	2D6							

* Code "60H" is available only Type "S"

JUKI

JUKI CORPORATION SEWING BUSINESS UNIT

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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. • APRIL, 2025 Printed in Japan(TN)

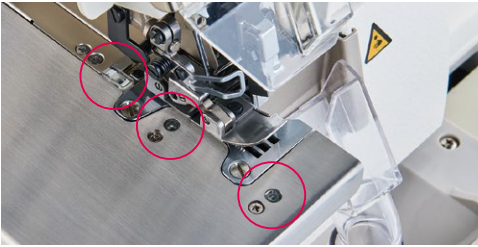


Registered Organization:
JUKI CORPORATION Head Office
The Scope of the Registration:
The activities of research, development, design, sales, distribution, and maintenance services of industrial sewing machines, household sewing machines and industrial robots, etc., including sales and maintenance services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

MO-6800AS(D)/DD Series

Automatic thread trimmer with a material sensor

The MO-6800AS(D)/DD Series of sewing machine is provided as standard with the side cutter with 2 material sensors (DD22) and the Tape cutter with 3 material sensors (DD23). Under the full-automatic mode, the material sensor detects the presence / absence of the material to prevent the operator from erroneously operate the side cutter etc. In addition to the full-automatic mode, the manual mode and the semi-automatic mode can be selected.



3 material sensors

Model	Direct-drive motor Integrated head / panel	Sensor control	Side cutter	Tape cutter	Automatic foot lifter	Waste removal suction device	Remarks
			Pneumatic	Pneumatic	Pneumatic	Pneumatic	
DD10	●	—	*	*	*	*	*: Can be retrofitted With device
DD22	●	● 2 material sensors	●	—	●	●	
DD23	●	● 3 material sensors	—	●	●	●	

Operator fatigue reduction (LED light) Standard equipment with all series

For the LED light, the improved toning function with two additional colors (Cool White / Warm white) is provided. Illuminance of the LED light is adjustable in five levels. This LED light helps reduce the operator's eye fatigue who is engaged in sewing work for a long time.



Mixed color



Cool White



Warm white

Operation panel and control box are integrated with the machine head

The energy-saving and highly efficient servomotor is installed in the direct-drive style. The sewing machine quick lystarts up and stops with increased accuracy, thereby demonstrating improved responsiveness.

USB port

The USB port is standard on the control panel and You can easily upgrade the software. The MO-6800AS (D)/DD22, 23 has another one USB port for charging a mobile phone, etc.

Panel for DD22, DD23



USB Port 1

USB Port 2

Panel for DD10



USB Port

MO6814AS/DD10

Devices And Attachments

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)	

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 differentialfeed 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

	AS	MO6804AS0E430H DD10*, DD22*	L~M	1	3	—	4.0	2	3.8	1:0.7~1:2	6.0	DCx27 #11	7,000	
	AD	MO6804AD0E430H DD10*	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)

	AS	MO6804AS0A4150 DD10*, DD22*	EL~L	1	3	—	1.5	2	3.8	1:0.7~1:2	6.0	DCx1 #8	7,000	
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●2-needle overlock

For runstitching in general fabric

	AS	MO6814ASBD630H DD10*, DD22*	L~M	2	4	2.0	3.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6814ASBE630H DD10*	L~M	2	4	2.0	4.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6814ASBE640H DD10*, DD22*	M~H	2	4	2.0	4.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	6,500	
		MO6814ASBE630P DD10*, DD22*	L~M	2	4	2.0	4.0	3	3.8	1:0.7~1:2	5.0	DCx27 #11	7,000	Anti-material-slip
	AD	MO6814ADBD630H DD10*, DD22*	L~M	2	4	2.0	3.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6814ADBE630H DD10*	L~M	2	4	2.0	4.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6814ADBE640H DD10*, DD22*	M~H	2	4	2.0	4.0	3	3.8	1:0.7~1:2	7.0	DCx27 #11	6,500	
		MO6814ADBB630P DD10*, DD22*	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
		MO6814ADBE630P DD10*, DD22*	L~M	2	4	2.0	4.0	3	3.8	1:0.7~1:2	5.0	DCx27 #11	7,000	Anti-material-slip

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

	AS	MO6814ASBD624HG44 DD10*, DD22*, DD23*	L~M	2	4	2.0	3.0	3	3.8	1:0.7~1:2	5.5	DCx27 #9	7,000	
		MO6814ASBE624HG44 DD10*, DD22*, DD23*	L~M	2	4	2.0	4.0	3	3.8	1:0.7~1:2	5.5	DCx27 #9	7,000	
		MO6814ASBD634HG44 DD10*, DD23*	L~M	2	4	2.0	3.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6814ASBE634HG44 DD10*, DD22*, DD23*	L~M	2	4	2.0	4.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6814ASBE644HG44 DD10*, DD22*, DD23*	M~H	2	4	2.0	4.0	3	3.8	1:0.7~1:2	7.0	DCx27 #14	6,500	
	AD	MO6814ADBD624HG44 DD10*, DD22*, DD23*	L~M	2	4	2.0	3.0	3	3.8	1:0.7~1:2	5.5	DCx27 #9	7,000	
		MO6814ADBE624HG44 DD10*, DD22*, DD23*	L~M	2	4	2.0	4.0	3	3.8	1:0.7~1:2	5.5	DCx27 #9	7,000	
		MO6814ADBE634HG44 DD10*, DD22*, DD23*	L~M	2	4	2.0	4.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6814ADBE644HG44 DD10*, DD22*, DD23*	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

	AS	MO6816ASDE630H DD10*, DD23*	L~M	2	5	3.0	4.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6816ASFF630H DD10*, DD22*, DD23*	L~M	2	5	5.0	5.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6816ASFF650H DD10*, DD23*	L~M	2	5	5.0	5.0	3	3.8	1:0.7~1:2	7.0	DCx27 #16	6,500	
		MO6816ASFH650H DD10*	L~M	2	5	5.0	6.0	3	3.8	1:0.7~1:2	7.0	DCx27 #16	6,500	
		MO6816ASFF660H DD10*	H	2	5	5.0	5.0	3	4.5	1:0.9~1:1.7	7.0	DCx27 #21	6,000	
		MO6816ASFH660H DD10*, DD23*	H	2	5	5.0	6.0	3	4.5	1:0.9~1:1.7	7.0	DCx27 #21	6,000	
		MO6816ASDE430P DD10*, DD23*	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
		MO6816ASDE430HE35 DD10*, DD23*	L~M	2	5	3.0	4.0	2	3.8	1:0.7~1:2	5.0	DCx27 #11	7,000	
	AD	MO6816ADDE430H DD10*	L~M	2	5	3.0	4.0	2	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6816ADFF650H DD10*	L~M	2	5	5.0	5.0	3	3.8	1:0.7~1:2	7.0	DCx27 #16	6,500	
		MO6816ADDE430HE35 DD10*, DD23*	L~M	2	5	3.0	4.0	2	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	
		MO6816ADDE430P DD10*	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

●3-needle safety stitching

	AS	MO6843AS1D640H DD10*, DD23*	M~H	3	6	5.0+2.0	3.0	3	3.8	1:0.7~1:2	6.5	DCx27 #11	7,000	
		MO6843AS2D640H DD10*, DD23*	M~H	3	6	3.0+2.0	3.0	3	3.8	1:0.7~1:2	6.5	DCx27 #11	7,000	
	AD	MO6843AD1D640H DD10*, DD23*	M~H	3	6	5.0+2.0	3.0	3	3.8	1:0.7~1:2	5.5	DCx27 #11	7,000	

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

	AS	MO6845ASFF6360N075 DD10*	L~M	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
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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

*sti/min is the abbreviation for "stitches per minute"