1. There are 103 more possible op codes
2. You would need to add several new op codes. To compare you need to subtract and be able to compare the answer to determine if they match. To push or pull from a stack, there needs to be a stack register or some way to keep track of the stack. To take the 2’s complement of a number you need to XOR with a max value and add one to it. This can be done by performing the operations that are already implemented.
3. You would need to keep track of what the operations were decoded to, such as keep track of the operation being AND from Memory to ACC, and pass that into the execute part of the program
4. You can break out the sections such as pulling from memory or putting into memory for 16-bit numbers. Anything with duplicate code in the program can be broken out into anther method.