The eyebrows run the wrong direction. The portrayal in the Manoppello-picture is therefore physignomically-anatomically wrong. Eyebrow hairs on humans run from the nosebridge towards the temples, so that sweat drips off the nose and not into the eyes.

The eye look is wrong too: looking straight facing another person the pupils and the iris should be in the middle of the horizontal eye axis. No white of the eye is visible in this case.

This eye look would come, if one bows down his head towards the chest and looks upwards – you can check in the mirror. A trained portrait painter will recognize that the eyes are too big. This usually happens to an untrained portrait painter or artist student according to Mr Kinn / phantom image painter and portrait painter at LKA Mainz.
Concerning mouth and lips: the incisor teeth are anatomically wrongly placed with the cupid’s bow: The two middle incisor teeth should be left and right from the cupid’s bow. Here but is one incisor tooth centered with the Cupid’s bow. Tip of the nose and Cupid’s bow should be in a vertical line. Because the woven fabric is distorted towards left, tip of the nose, cupid bow and incisor tooth would be in a vertical line. Because of distortion it is not so here. Would the woven fabric be placed without distortion, the anatomically wrong position of the centered incisor tooth would even be seen more striking.

Very clearly this is an artificial product showing the stylized hairs of a “teenagers beard,” which does not have any similarity to the mature man’s beard on the shroud of Turin.
Concerning the mouth opening, only the teeth of the underjaw should be visible, not the upper row of teeth. Only by laughing strongly is the upper lip drawn back enough, so that the upper row of teeth including incisor teeth is visible. Also anatomically wrong is that the incisor teeth form one line with the neighboring teeth. Every dentist will confirm that here there is no anatomically correct tooth image.

It can be seen that the teeth could have been longer at one time, but then the mouth should be shown more open. For there is no possibility of correcting the lip line on this fine fabric, the teeth were covered darkly to widen the mouth, and now it appears as a row of teeth, which is anatomically wrong.
Here a sketch showing the eyes looking straight facing a person. That’s the correct straight forward look.
In comparison the anatomically wrong portrayal on the Manoppello image

Here, a woman’s eye with eyebrow in comparison. A man’s eyebrow would be stronger, as it is indeed on the Shroud of Turin. Very clearly, the Manoppello image drawing of the eyebrows is in the wrong direction, and the form of the eyebrows is also incorrect.

We can clearly see that the eyes at Manoppello do not look at the onlooker, but look somehow aside. This, as well as the oversized eyes and pupils, can happen with an untrained painter who is not a master in portrait painting. The half closed eye lid does not fit to the fully opened eye. These are several anatomical mistakes.
Here you see how the tip of the nose and Cupid’s bow are correctly aligned vertically.

And only by laughing strongly do the upper row of teeth with the incisor teeth left and right of the Cupid’s bow becomes visible.
The proportions of the head are anatomically wrong: the axis of the eyes divides the head into 2 equal halves. Here the upper half is 1/3 shorter. Concerning the Shroud of Turin the proportions are correct.
Here we can see the symmetry of a skull. The axis of the eyes divides the skull into 2 equal halves. Concerning the Manoppello image the upper half is much too short. Instead the shroud of Turin shows the anatomically right proportions.
Observing the left half of the face, we see in the upper part of the mouth, that the painter could not decide, what the mouth should express: sinistral without expression, dextral (next picture) there is a slight trace of a smile recognizable.
Here we see the trace of a smiling mouth, whereas this half of the face is much rounder (more curved). The cheek is unsymmetrically wider than the left half of the face. Of course this is not correct anatomically. Given that Jesus was perfect man and God, why should He create such an imperfect image?
The face on the shroud is much better and not comparable to this image!
Observing this detail of the hairline the painter must have had a person to be portrayed in front of him. This, as well as the mustache detail, was done by a trained painter, whereas the eyes and eyebrows were done by an untrained painter. This artificial hairline cannot be found on the shroud face. The painter here had a sitter with these characteristics. And it truly looks artificially done by human hands.

... and the curls of hair are in renaissance style ... and not to be found on the Shroud.