New employees must receive appropriate emergency response training when they begin work.

All employees must receive refresher training every year.

Employees must be retrained whenever the emergency plan is changed, either through revisions or amendments.

Workers must also be retrained whenever new equipment, materials, or processes are introduced into the facility, since any of these could create new hazards that could lead to emergency situations such as fires, explosions, or chemical releases.

Employees must be retrained when work procedures are updated or revised.

Workers must receive refresher training when emergency drills indicate that employee performance must be improved—for example, if during an evacuation drill, numerous employees fail to respond to the alarm or forget their designated escape routes.